

FIG. 1

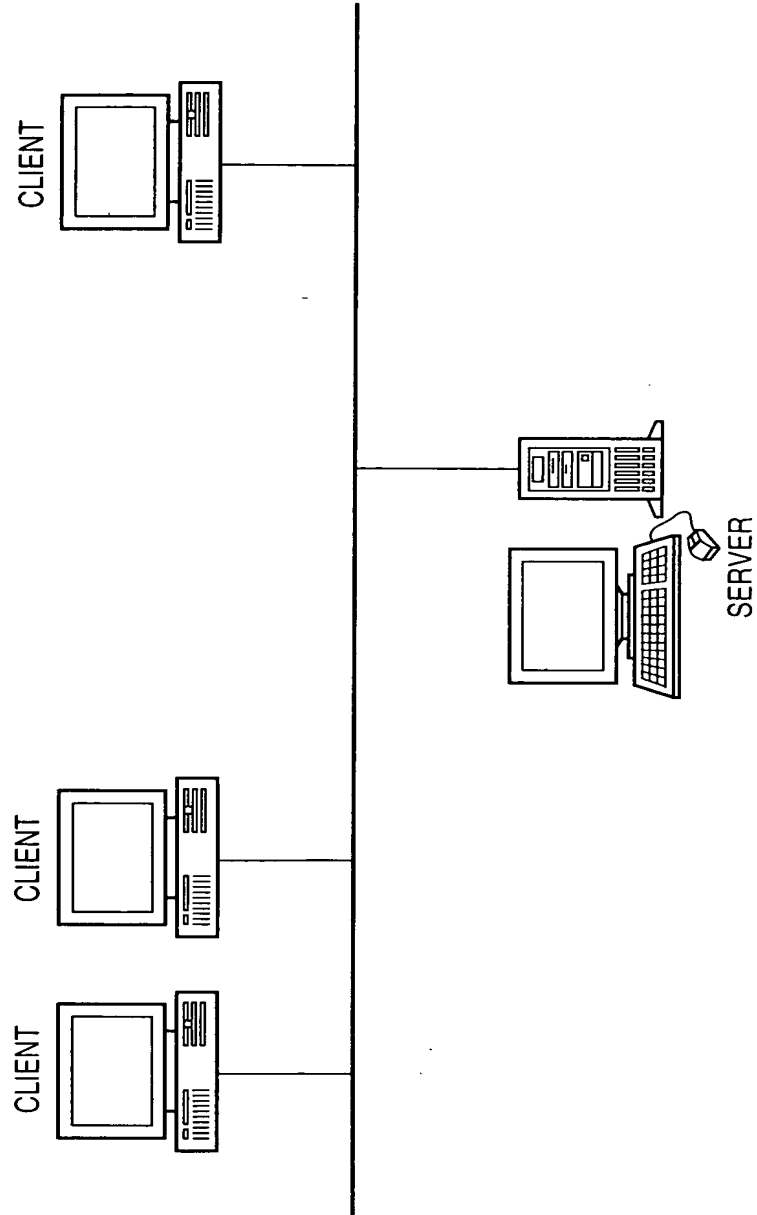
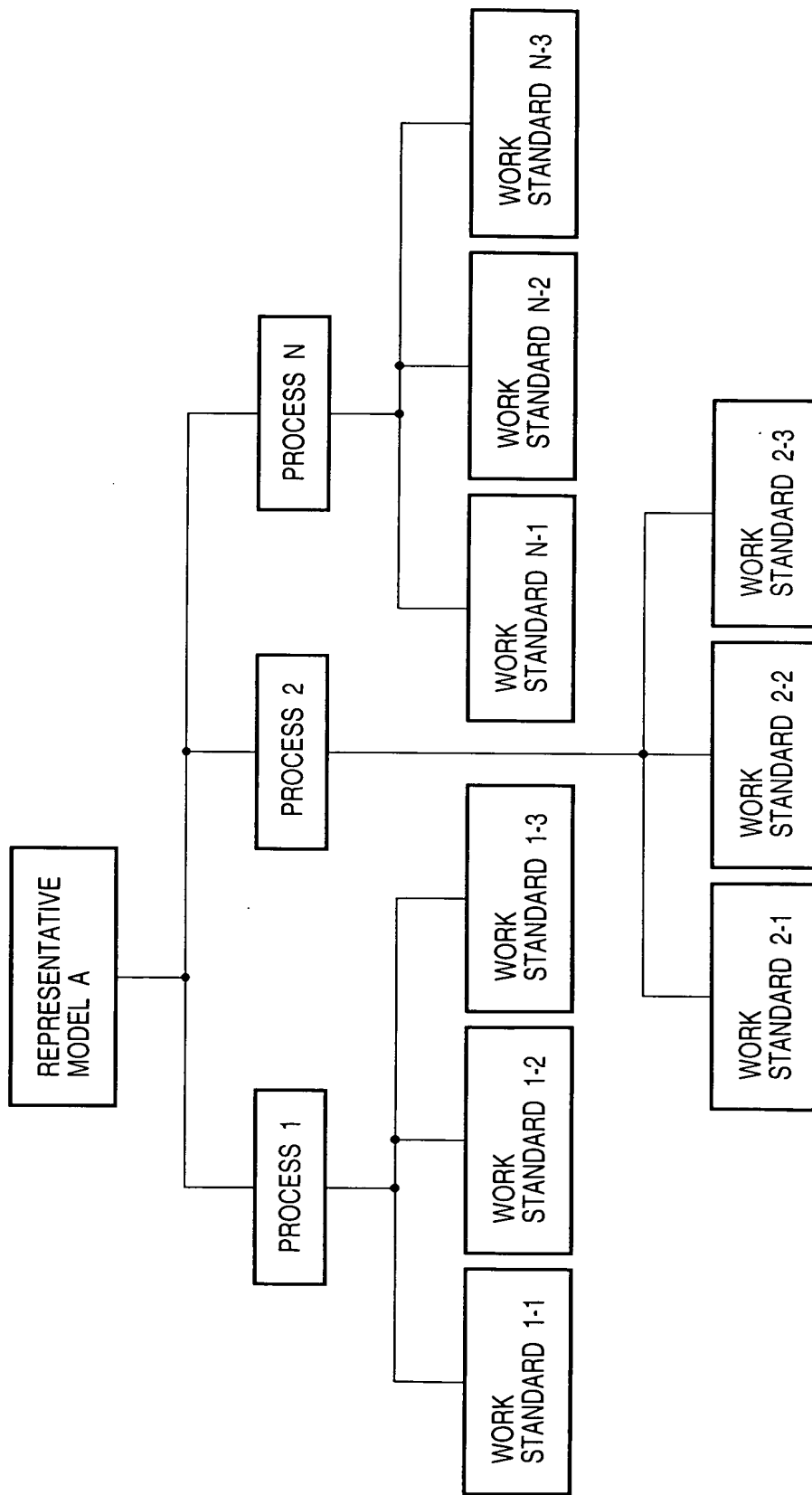


FIG. 2



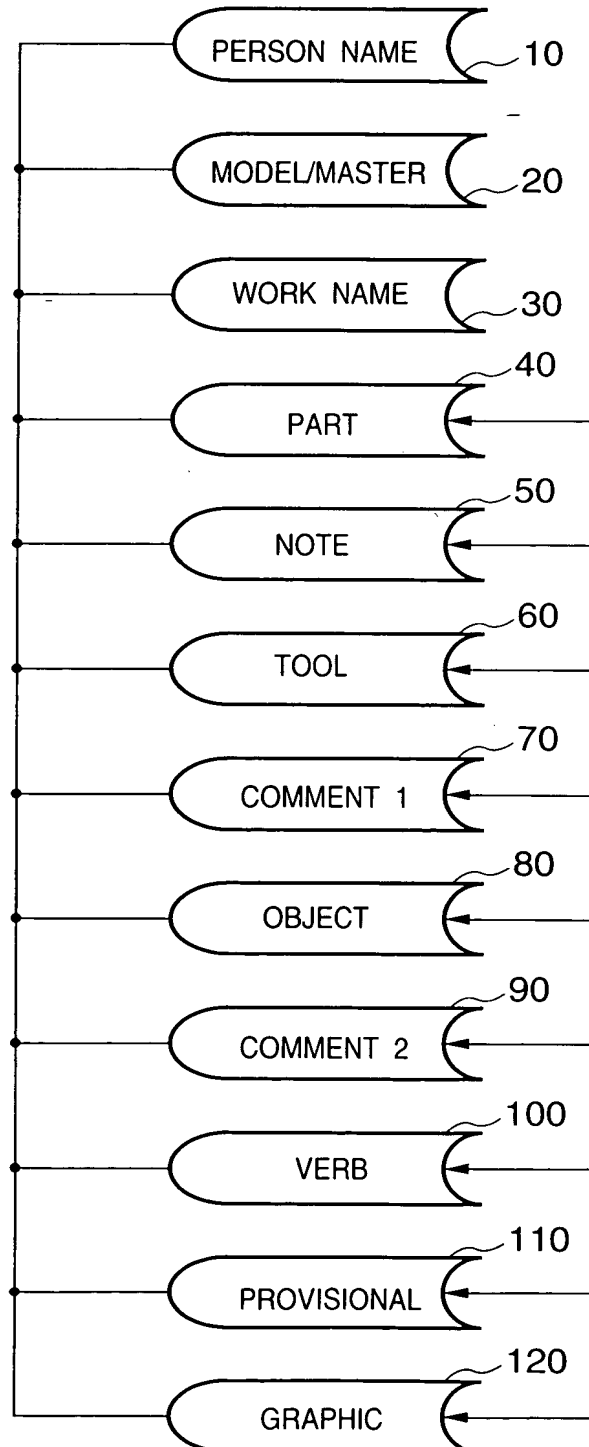
3/97

FIG. 3

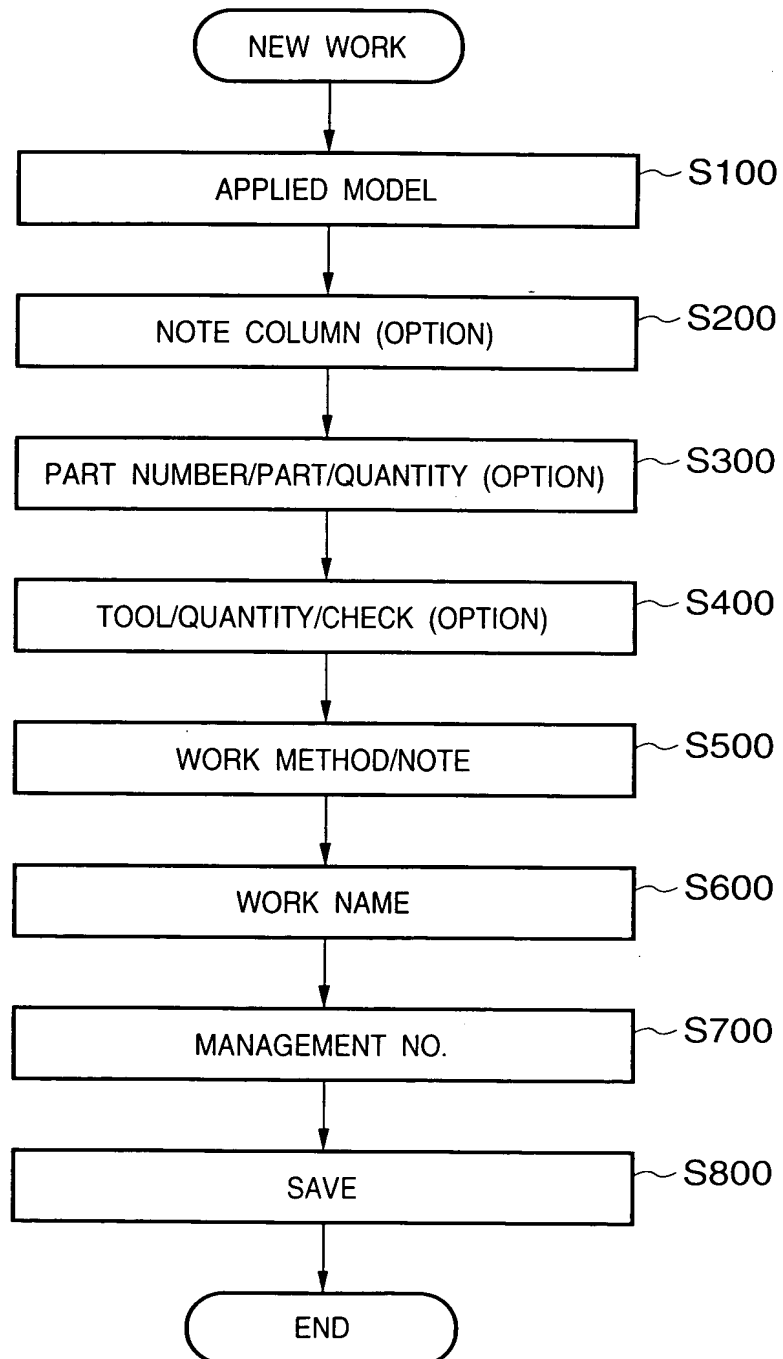
WORK STANDARD 01 CREATION				300	
APPLIED					
PART NUMBER				PART NAME	
303				304	
305				306	
307				308	
TOOL / TREATMENT DEVICE / AUXILIARY MATERIAL				CHECK ETC.	
309				310	
311				312	
313				314	
315				316	
317				318	
319				320	
321				322	
323				324	
325				326	
327				328	
329				330	
331				332	
333				334	
335				336	
337				338	
339				340	
341				342	
343				344	
345				346	
347				348	
349				350	
351				352	
353				354	
355				356	
357				358	
359				360	
361				362	
363				364	
365				366	
367				368	
369				370	
371				372	
373				374	
375				376	
377				378	
379				380	
381				382	
383				384	
385				386	
387				388	
389				390	
391				392	
393				394	
395				396	
397				398	
399				400	

FIG. 4

STRUCTURE OF MASTER FILE



T06T0T"024E5450

FIG. 5

6/97

FIG. 6

SELECTION OF APPLIED MODEL	
LIST OF APPLIED MODELS	
BJC-4200 SYSTEM	
BJC-420J	
BJC-420J (BLACK)	
BJC-4300	
BJC-430J	
BJC-4200LX	
A250 II Q	
BJC-4200	
OK	CANCEL

037533104904



302

8/97

FIG. 8

PART NUMBER	PART NAME	QUANTITY	PART NUMBER
PART			
000 - 0000 - 001	PART 001	▲ ▼	
000 - 0000 - 002	PART 002		
000 - 0000 - 003	PART 003		
001 - 0000 - 001	PART 101		
001 - 0000 - 002	PART 102		
111 - 1111 - 001	PART 001		
A01 - 1234 - 001	TEST PART 0001		

09753726-101501

FIG. 9

(LOCK DEVELOPER)

10/97

FIG. 10

• WORK NAME

• CANDIDATES

(HOOK DEVELOPING RAIL RETURN SPRING)
(HOOK DEVELOPING RAIL RETURN SPRING(AFTER))
(CHECK NO TONER IN DEVELOPER)
(CHECK ERROR IN DEVELOPER)
(LOCK DEVELOPER)

05733726 104904

FIG. 11

1100

WORK STANDARD SYSTEM

WORK NAME :

WORK METHOD :

1101 (COMMENT 1)

1102 (OBJECT)

1103 (COMMENT 2)

1104 (VERB)

00 ※ 1105a

01 1105b

1105

NOTE, STANDARD / REQUIRED QUALITY :

1106

1107

OK 1108 CANCEL

12/97

FIG. 12

09753726 104904
106101 9245260

WORK STANDARD SYSTEM	
WORK NAME :	
WORK METHOD :	
	1201
	1202
00 ※	1105b
01	

FIG. 13

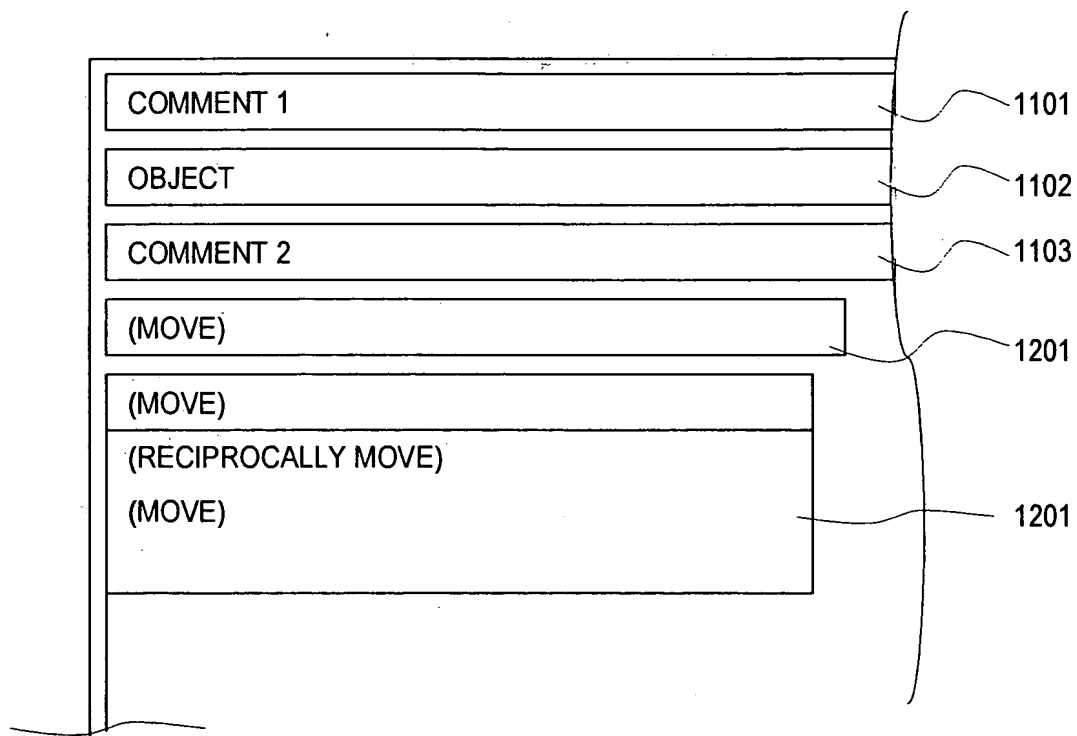
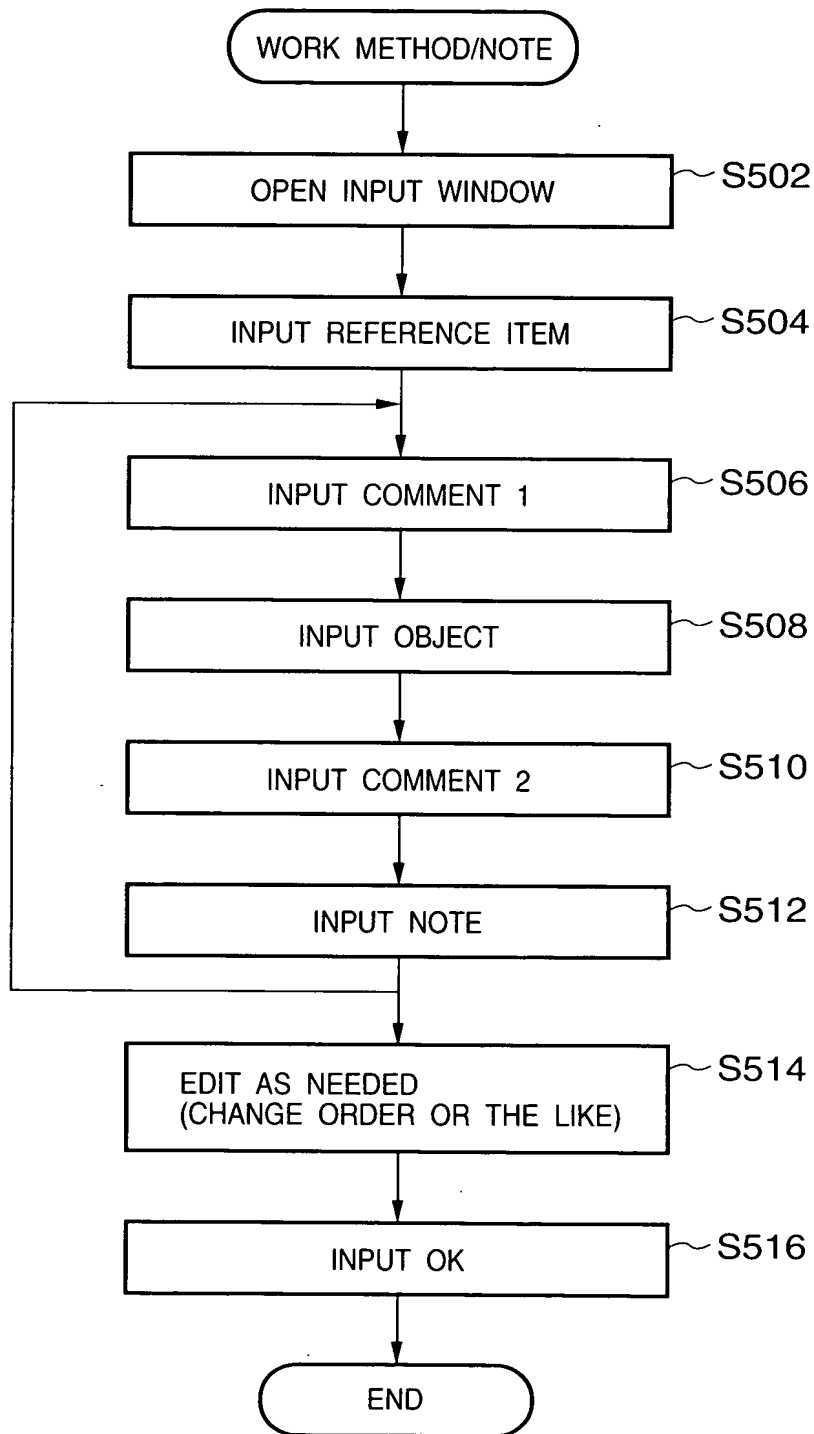


FIG. 14

**FIG. 15**

00	※	
01	DO zzzz SUCH THAT xxxx AT wwww POSITION BECOMES yyyy	
02	WIND AV CORD	
03	CONFIRM 100V SYSTEM	
04	SET CRG HOLDER	

09753726 101901

FIG. 16

NOTE, STANDARD / REQUIRED QUALITY

NOTE

SEPARATION GRIPPER MOVES SLOWLY WITHOUT GRIPPER SPRING OF ASFu
DON'T PULL TAPE TOO STRONG TO MAKE SIDE GUIDE LOOSE
DON'T HOOK PAPER GUIDE u ON SHEET HOLDER
BEWARE OF IMITATIONS
BEWARE OF IMITATIONS(Color Style Write

1601

1602

09/2010



FIG. 17

NOTE, STANDARD / REQUIRED QUALITY	
1	NOTE

1107

09753726.101901

FIG. 18

CONFIRM

00 ※

01 CONFIRM 100V SYSTEM

02 WIND AV CORD

03 SET CRG HOLDER

04

NOTE, STANDARD / REQUIRED QUALITY

CUT(I)

COPY(C)

PASTE(P)

ADD(A)

DELETE(D)

UNDO

REVISE(CHANGE)

REVISE(DELETE)

1802

19/97

FIG. 19

CONFIRM	
00	※
01	WIND AV CORD
02	CONFIRM 100V SYSTEM
03	SET CRG HOLDER
04	

NOTE, STANDARD / REQUIRED QUALITY

09753726 101504

FIG. 20

CONFIRM	
00 ※	
01 WIND AV CORD	
02 SET CRG HOLDER	
03	<div> CUT(I) COPY(C) PASTE(P) <hr/> ADD(A) DELETE(D) <hr/> UNDO REVISE(CHANGE) REVISE(DELETE) </div>
NOTE, STANDARD / REQUIRED QUALITY	

1802

69753726 101501

FIG. 21

WORK STANDARD SYSTEM	
WORK STANDARD(E)	EDIT(E) ILLUSTRATION(I) SHIPMENT DESTINATION
CREATE(N) Ctrl + N	X % [Icon] [Icon] ←
OPEN(O) Ctrl + O	
CLOSE(C)	
CLOSE ALL	
SAVE(S) Ctrl + S	
SAVE REVISE(A) Ctrl + A	
SAVE ALL	PART
DELETE(D)	
DELETE FROM LIST	
PREVIEW(V)	
PRINT(P) Ctrl + P	
PRINT FROM LIST	
END(X)	

09733733 104501

FIG. 22

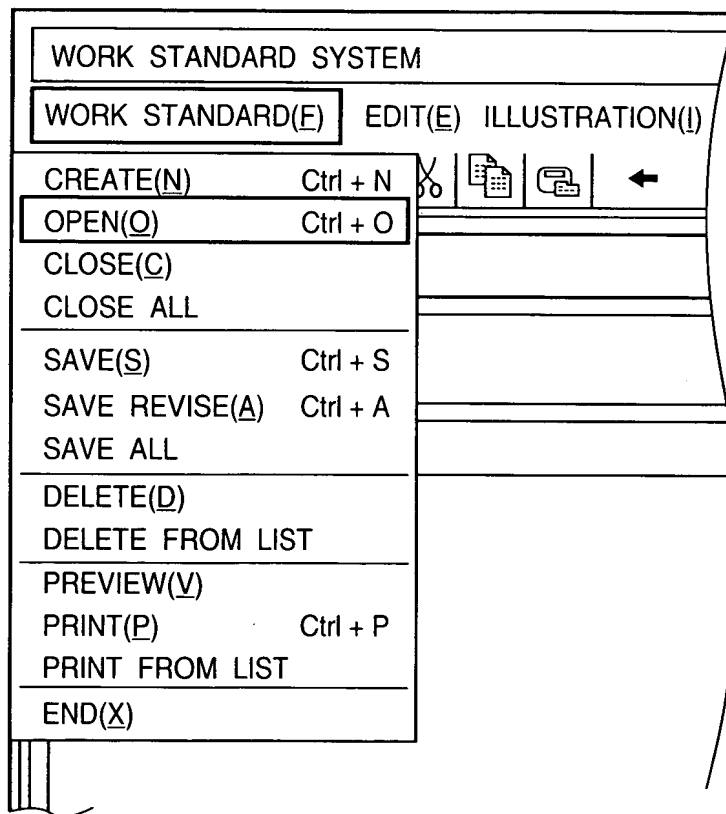


FIG. 23

WORK STANDARD SYSTEM





☒ LATEST REVISION NUMBER
 ☐ ALL

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	DATE OF REGISTRATION
SO-04-01(4)-E	01	SET ASFu	1997/09/13
SO-01-01(3)-E	01	SET BASE TRAY	1997/09/01
SO-01-03-E	01	SET BASE TRAY	1997/09/01
SO-01-04-E	01	SET BASE TRAY	1997/09/01
SO-06-01-E	01	WIRING	1997/09/01
SO-06-02-E	01	WIRING	1997/09/01
SO-06-03-E	01	WIRING	1997/09/01
SO-07-01(2)-E	01	GREASING	1997/09/01
SO-08-01-E	01	SET RAIL	1997/09/01

OK

CANCEL

**FIG. 24**

SYSTEM			
EDIT(E)		ILLUSTRATION(I)	SHIPMENT DESTINATION(S)
		VIEW(V)	 
		EDIT(E)	
01 CREATE		PowerPoint	
		✓ Canvas	

09753726 101501

FIG. 25

WORK STANDARD 01 CREATION

APPLIED

PART NUMBER

303

PART NAME

TOOL / TREATMENT DEVICE

WORK PROCEDURE

No.

FILE NAME :

2501 2502 2503 2504

UPDATE

CLEAR

CLOSE

2500

REVISION NUMBER

01

CONTENTS OF REVISION

CREATED

DATE

1997/09/25

PERSON IN CHARGE

APPROVE

WORK NAME

MANAGEMENT NO.

FIG. 26

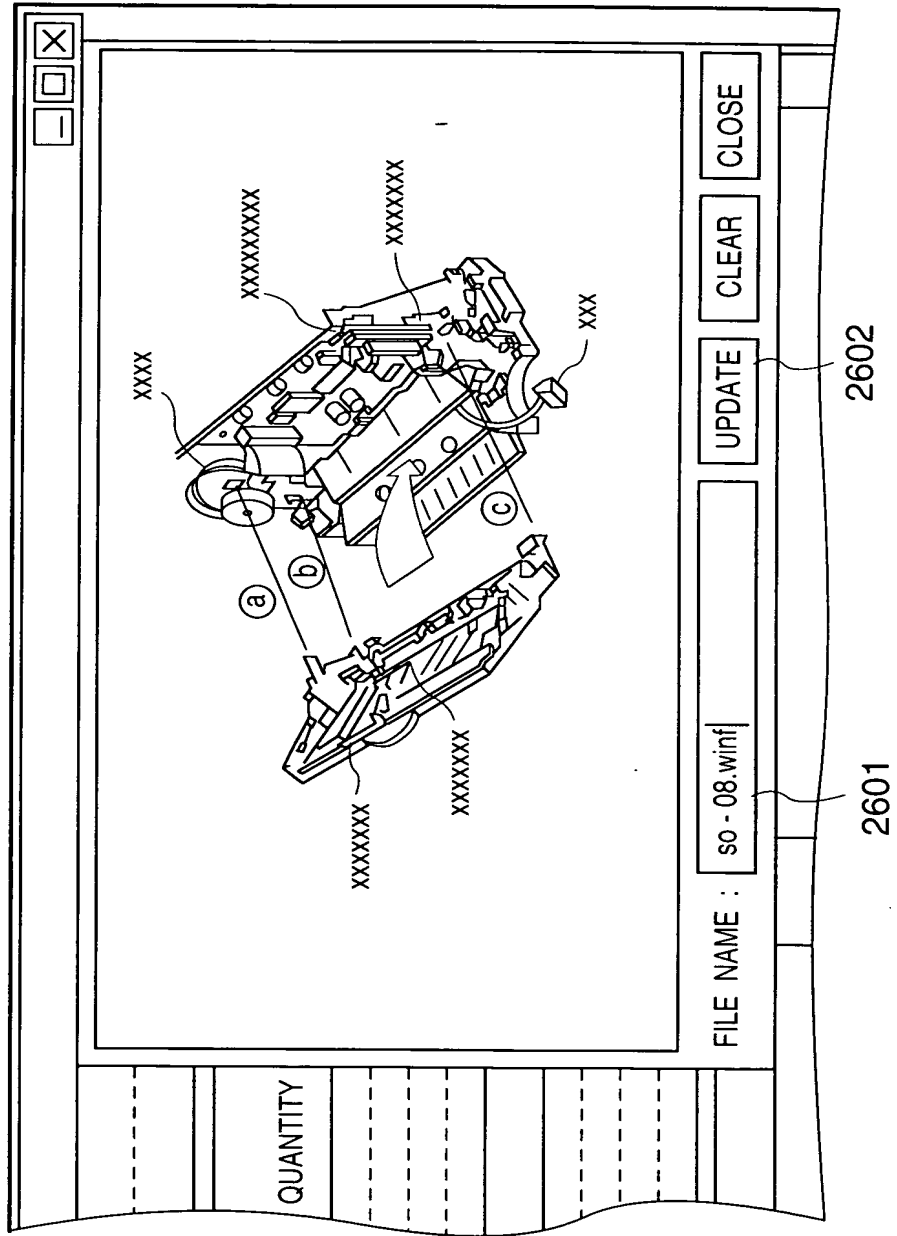
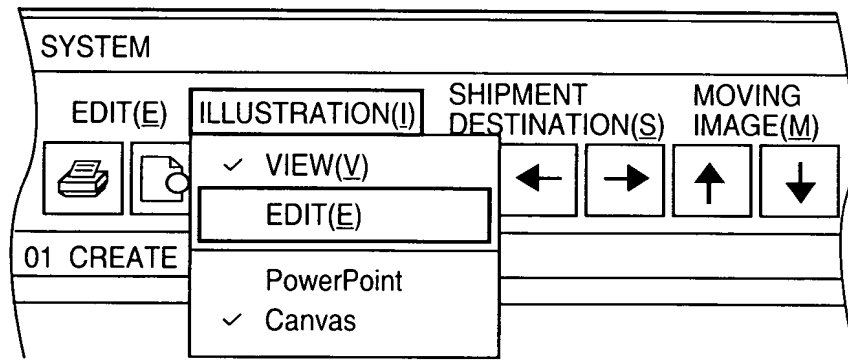


FIG. 27



09753726-101901

FIG. 28

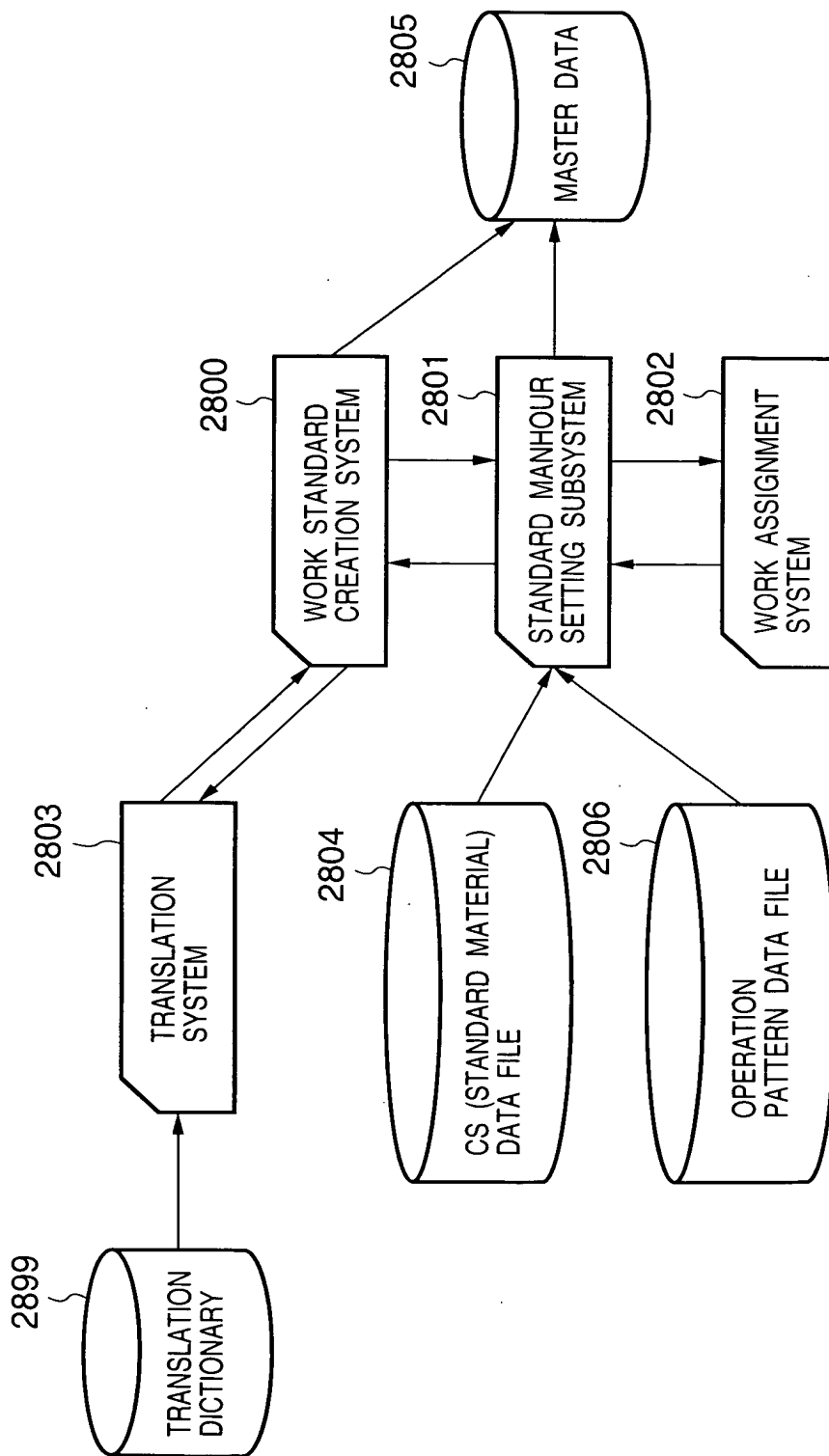




FIG. 29

WORK STANDARD : TRANSLATION SYSTEM (PROTOTYPE) ☒

☒ WORK STANDARD DATA
☐ MASTER DATA

UPLOAD WORK STANDARD

DOWNLOAD WORK STANDARD

TRANSLATE WORK STANDARD

END

09753726 104504

FIG. 30

3001
3002
3003
3004

TRANSLATION OF WORK STANDARD

REPRESENTATIVE MODEL NAME : A252

PREPUCES NAME : PLATEN UNIT

☐ TOTAL
☒ ASSEMBLY

DISPLAY DATA

☒ ALL
☐ UNTRANSLATED
☐ UNCHECKED

DISPLAY LANGUAGE

☐ JAPANESE
☒ ENGLISH

3006
3007
3008
3005

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	AUTOMATIC TRANSLATION CHECK
PT - 010 - 010	01	SET CLEANER UP	X
PT - 010 - 020	01	SET CLEANER UP	X
PT - 010 - 030	01	SET CLEANER UP	X
PT - 070 - 030	01	ASSEMBLE CHANGEOVER ARM	X
PT - 080 - 010	01	SET TRANSMISSION ROLLER	X
PT - 090 - 010	01	SET TRANSMISSION ROLLER	X
PT - 100 - 010	01	SET SHEET HOLDER	X

SELECT ALL

CANCEL SELECT

VIEW

TRANSLATE

TRANSLATE ALL

CLOSE

3006

FIG. 31

TRANSLATION OF WORK STANDARD (PROTOTYPE)									
WORK STANDARD(E) ILLUSTRATION(I) VOICE(S) WINDOW(W)									
WORK STANDARD PN-030-020 01 New created by (PX2056) A252 PUMP UNIT									
Model	QG5-1319								
Part No.	Part Name	Qty	Part No.	Part Name	Qty				
Total					Qty	PN			
No.	Procedure			No.	Precaution / Conditions				
01	The blade lever spring hooks to ① of the blade lever.								
02	Side the blade lever in the direction of arrow ② and check there is no catch and nor the return by the spring force.			02 - 01	No Table Data 1				
03	Check press-fitting the blade lever shaft leading edge to the braid folder leading edge.			03 - 01	No Table Data 1				
Details is of Revision				Data	By	OK			
01	New Created by (PX2056)					No Table Data 1			
						Page No.			
						PN-030-020			

FIG. 32

3200

WORK PROCEDURE

X

VOICE(W)

JAPANESE

WORK PROCEDURE

ブレードレバ-ハネをブレードレバ-の ① 部に引っ掛ける

3201

01 ブレードレバ-ハネをブレードレバ-の ① 部に引っ掛ける

02 ブレードレバ-を矢印 ② 方向にスライドさせ引っ掛かり無くハネ力で戻ることを確認する

03 ブレードレバ-軸先端がブレードホルダ-先端まで圧入されていることを確認する

3202

ENGLISH

Procedure

The blade lever spring hooks to ① of the blade lever.

3203

01 The blade lever spring hooks to ① of the blade lever.

02 Side the blade lever in the direction of arrow ② and there is no catch and n....

03 Check press-fitting the blade lever shaft leading edge to the braid folder leading ed....

3204

TRANSLATE

OK

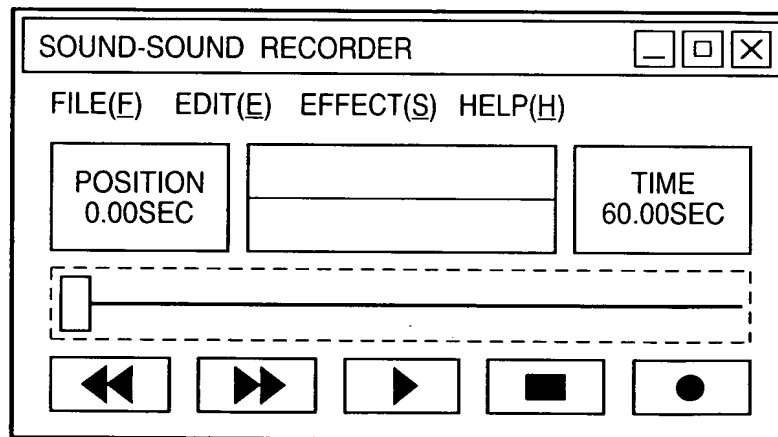
CANCEL

FIG. 33

FIG. 33

TRANSLATION OF WORK STANDARD (PROTOTYPE)		<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
WORK STANDARD(E) ILLUSTRATION(I)		VOICE(S) DOW(W)	
WORK STANDARD PN-030-020 01 Ne		<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
Model QG5-1317		X2056) A252 PLATEN UNIT	
<div> <div>PLAY(P)</div> <div>NEW(N)</div> <div>DRIVE(D)</div> </div>		<div> <div>Model</div> <div>QG5-1317</div> </div>	

FIG. 34



09753726-101501

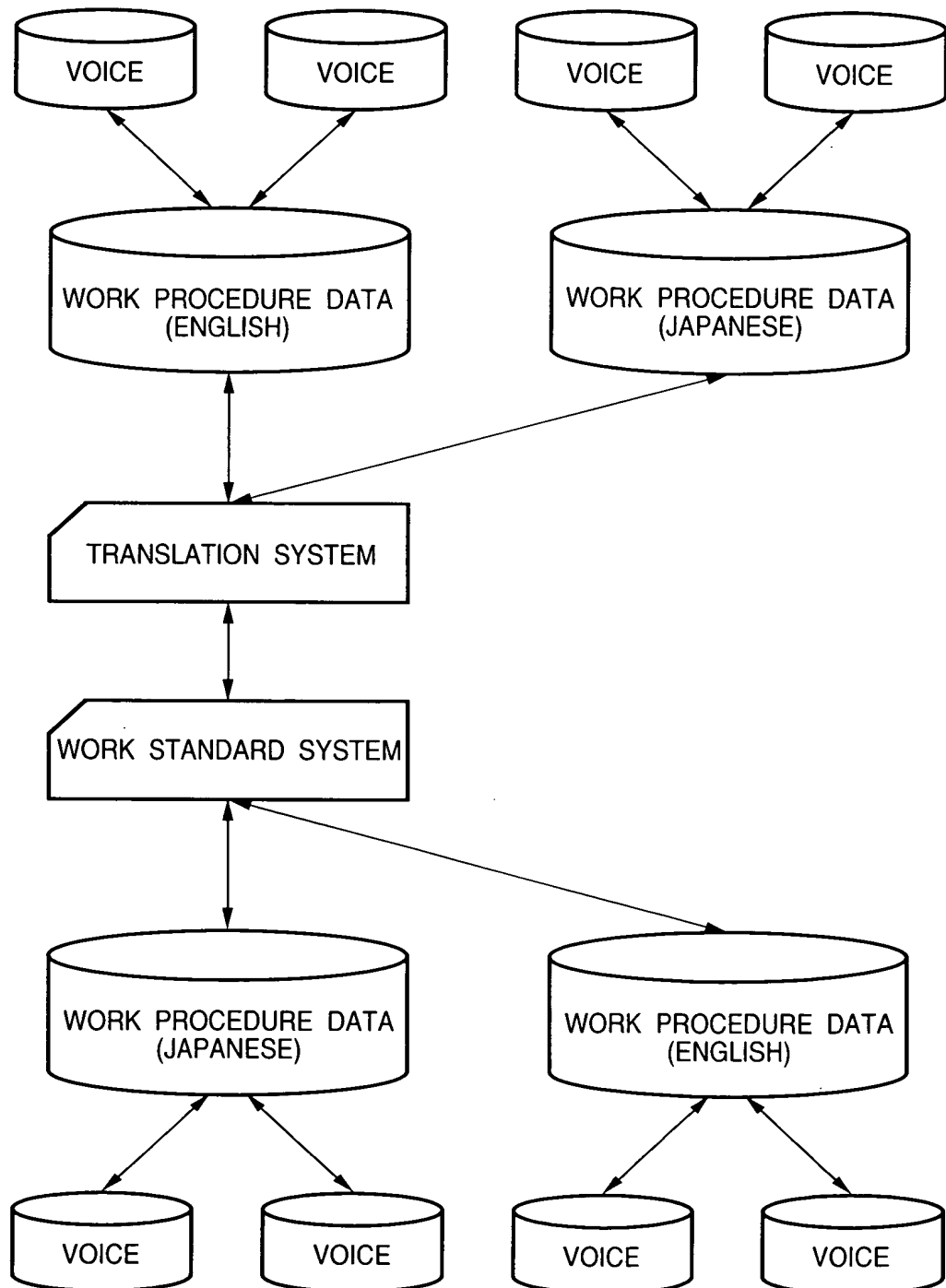
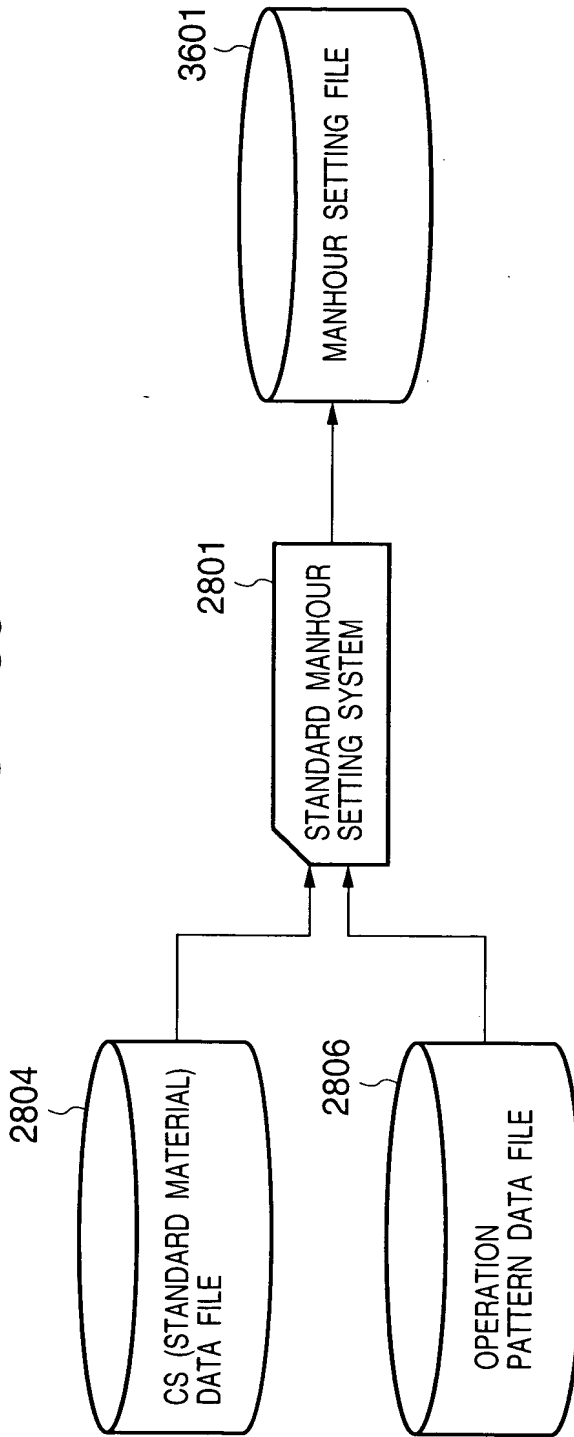
FIG. 35

FIG. 36



total 32260

FIG. 37

No.	ELEMENT WORK NAME	FREQUENCY		MANHOUR	CS	SET CONDITION



FIG. 38

STANDARD MATERIAL DATA

COMMENT 1	OBJECT	COMMENT 2	VERB	SET CONDITION DATA

FIG. 39

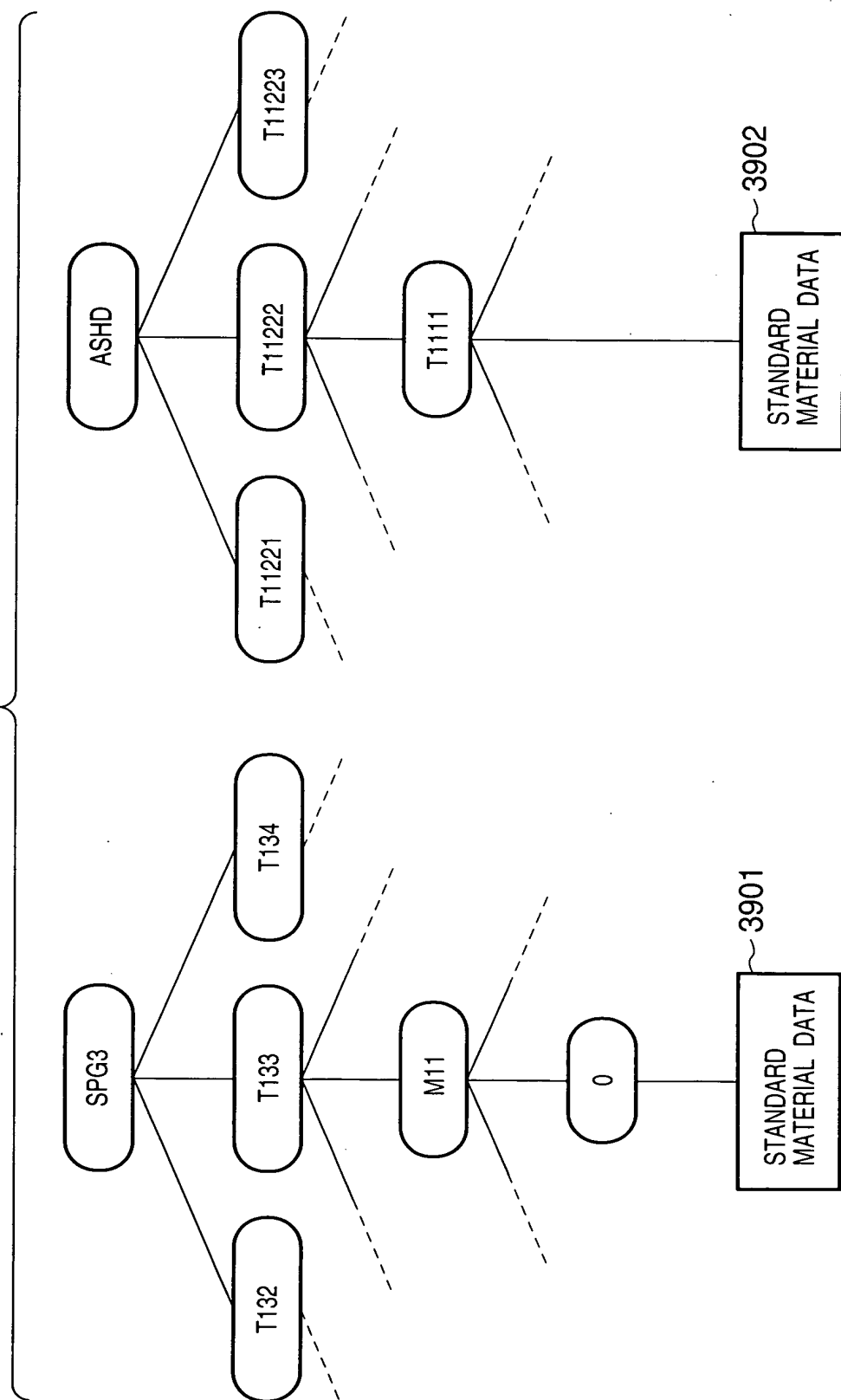
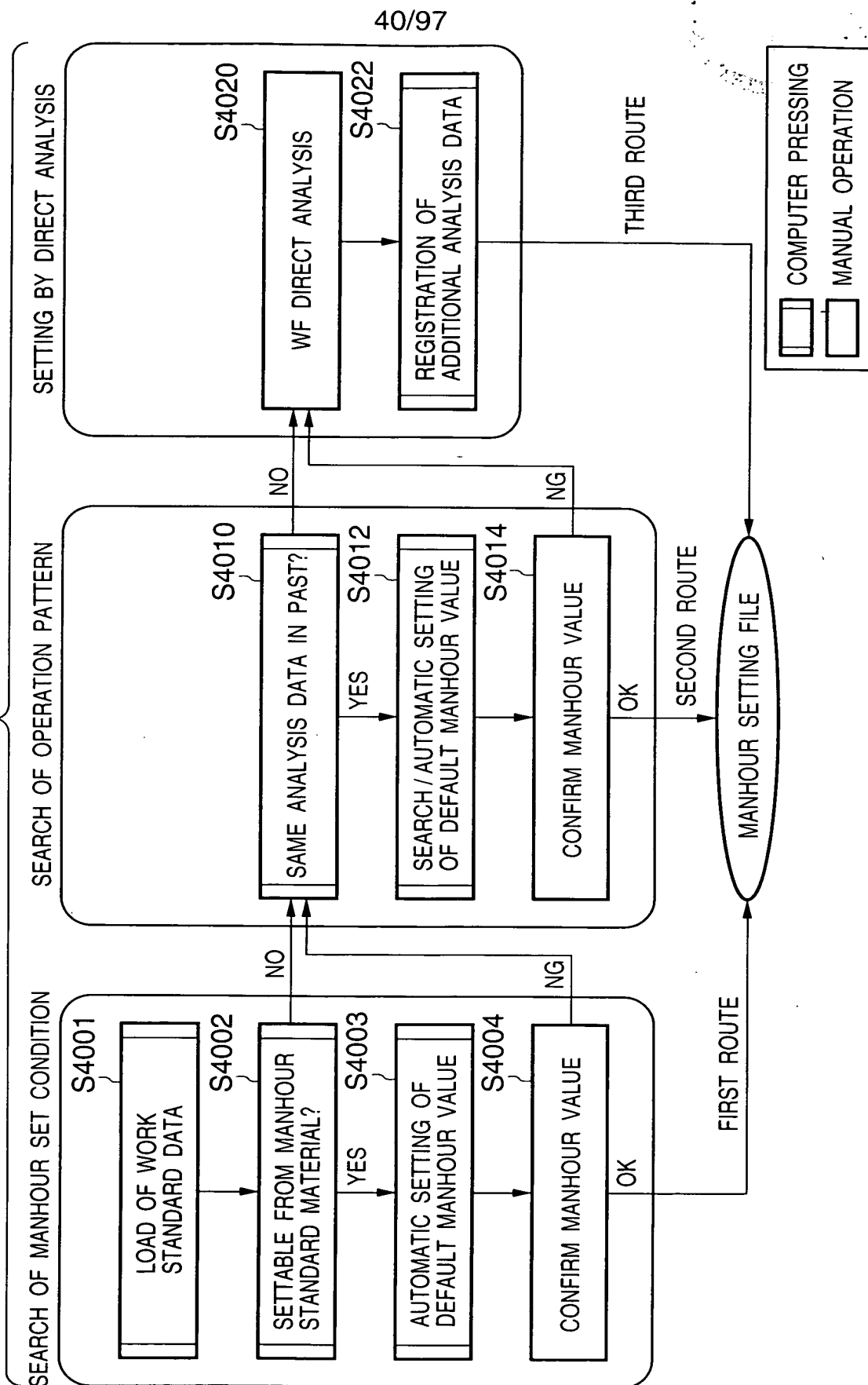


FIG. 40



42/97

FIG. 42

3601

EDITING OF ELEMENT WORK						
FILE(F) EDIT(E) VIEW(V) ANALYZE(A) ANALYSIS MATERIAL(B) CS(S) END(X)						
UNIT WORK NAME : SEPARATION ROLLER ATTACHMENT						
No.	ELEMENT WORK NAME	FREQUENCY		MANHOUR	CS	SET CONDITION
1	(SET LOAD SPRING IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1	41	SPG3	T133/M11 / 0
2	(TURN ON SW OF TREATMENT DEVICE)	1	1	8		
3	(SET SEPARATION ROLLER SHAFT IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1	37	ASHD	T11222 / T1111
4	(TURN OFF SW OF TREATMENT DEVICE)	1	1	8		
5	(DETACH SEPARATION ROLLER SHAFT FROM TREATMENT DEVICE)	1	1	16	PUMB	T2111 / T111111

MATCH

SEARCH KEYWORD (KW)

No.	COMMENT 1	OBJECT	COMMENT 2	VERB	MANHOUR STANDARD MATERIAL	TIME VALUE
1	*	SPRING	TO *	SET	SPG3 T133/M11/0	41RU
2	*	*	TO *	SET	ASHED T11222/T1111	37RU
3	*	*	FROM *	DETACH	PUMQ T2111/T111111	16RU
4	*	E-RING	*	SET	RIN2 T11211/SO	76RU
5	*	CONNECTOR	*	INSERT	CONN T11211/SO	41RU
6	*	*	*	SCREW TIGHTLY	SCR6 M211/1	23RU

2804

FIG. 43

[illegible]

MATCH

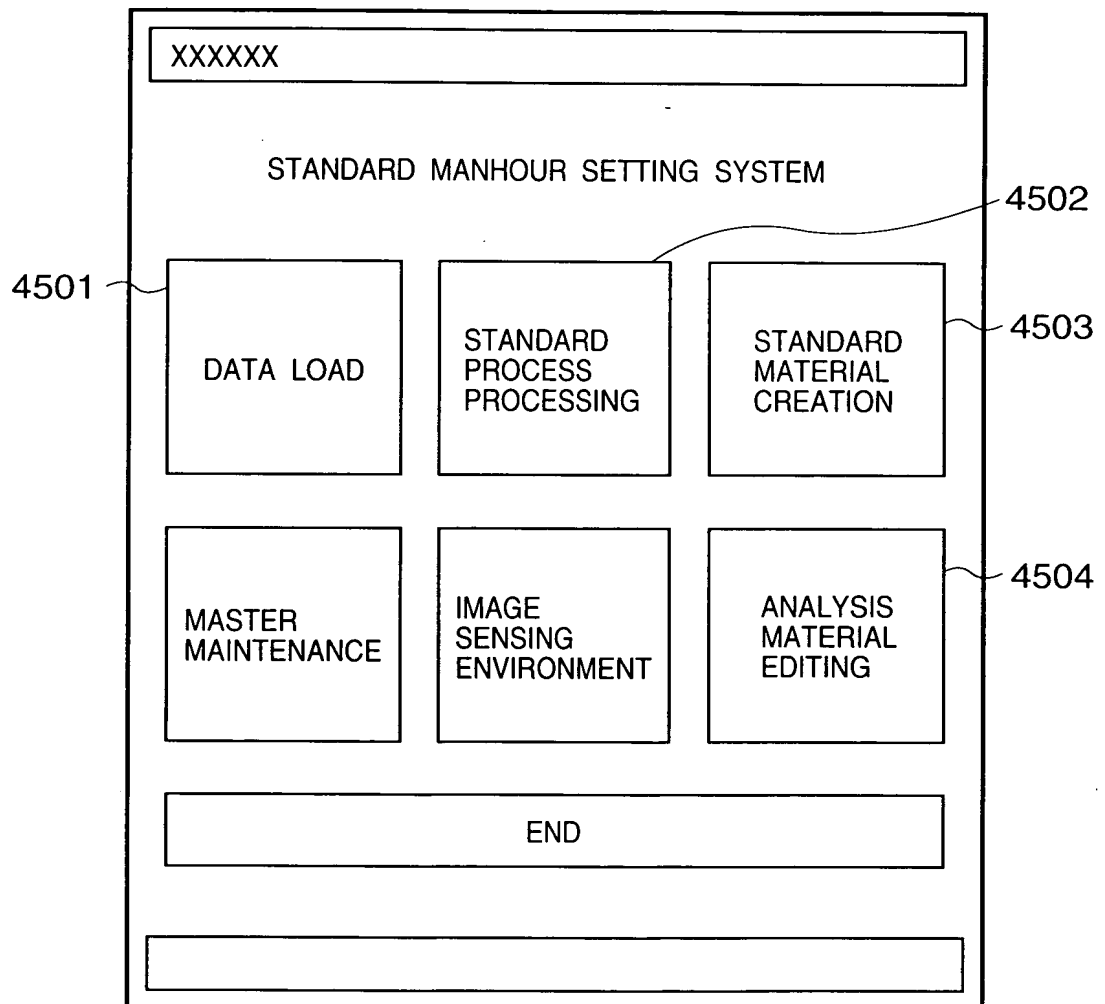
No.	COMMENT 1	OBJECT	COMMENT 2	VERB	VERB PATTERN	TIME VALUE
1	TREATMENT DEVICE	SW		TURN ON	/GET:-50E/M:-10E	8RU
2	TREATMENT DEVICE	SW		TURN OFF	/GET:-50E/M:-10E	8RU
3		READING OPERATION UNIT		CLOSE	/GET:-50E/M:-50E	10RU
4		CRG DOOR		CLOSE	/GET:-50E/M:-50E	10RU
5		READING OPERATION UNIT		CLOSE	/GET:-50E/M:-50E	10RU
6		POWER CODE		PULL OUT	/GET:-50Egr2/M:-10E	16RU
7		POWER CODE FOR MEASUREMENT		PULL OUT	/GET:-50Egr2/M:-10E	16RU

2806

3601

[illegible]

FIG. 45



4601

FIG. 47

[illegible]

FIG. 48

LOAD OF DATA

COMPONENT DESIGNATION

☐ ALL

☒ DESIGNATE COMPONENT

CH

AUTOMATIC MANHOURLY SETTING

☒ STANDARD MATERIAL(CS)

☒ ANALYSIS MATERIAL

EXECUTE

CANCEL

4800

4801

4802

4803

4804

4805

4806

FIG. 49

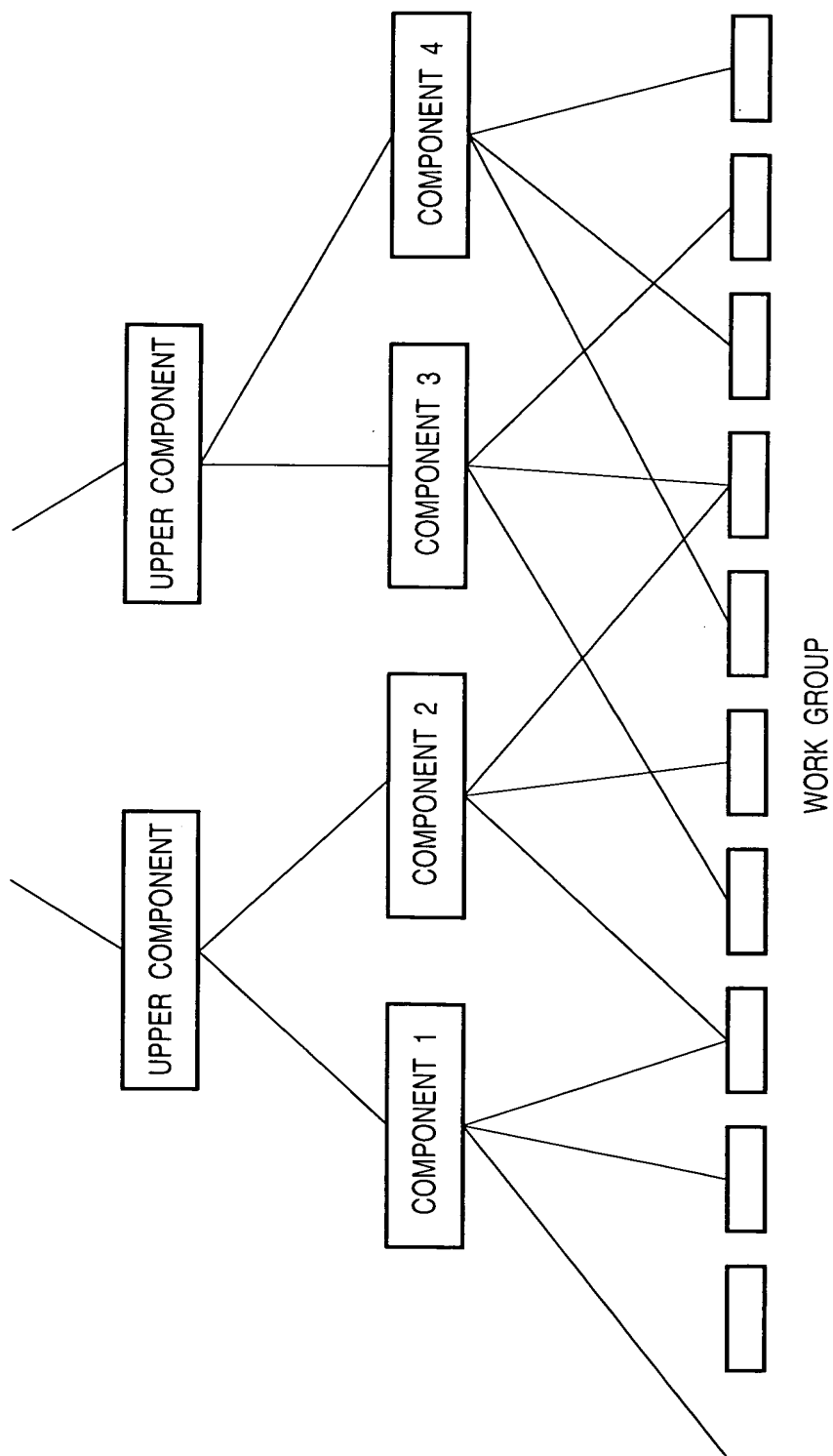


FIG. 50

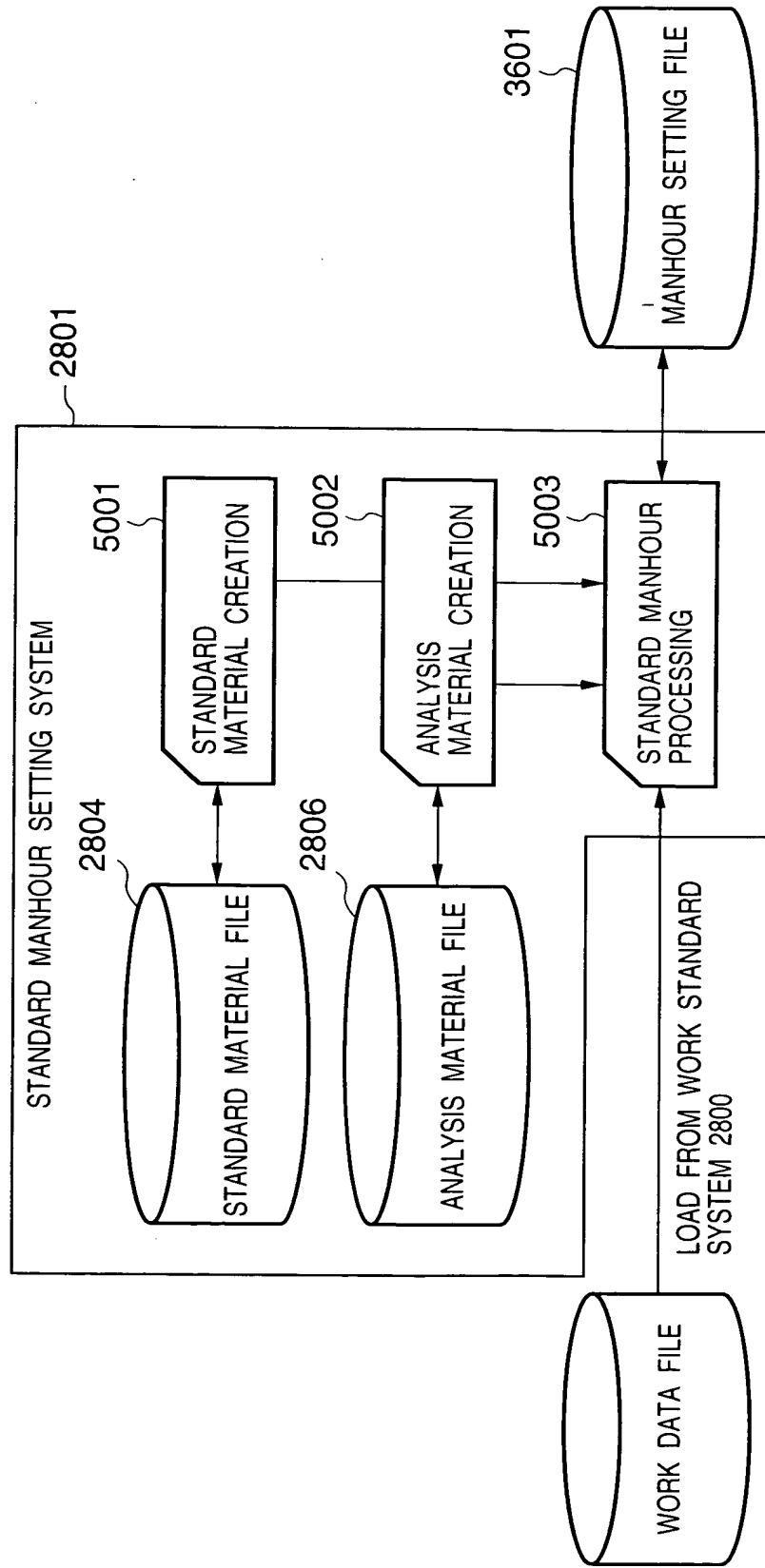
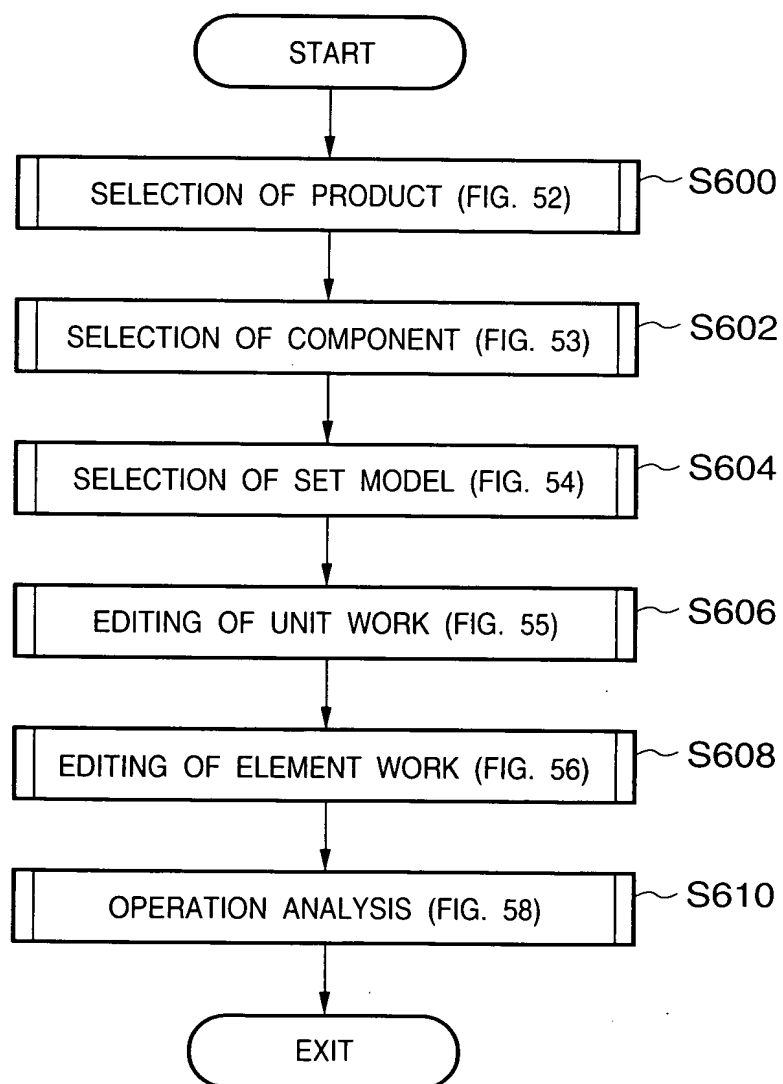


FIG. 51

SELECTION OF PRODUCT			
FILE(E) EDIT(E)			
PRODUCT SYMBOL	NAME	PREVIOUS UPDATE DATE	
BJ - 970909	XXXXX	1997/09/22 10:17:30	
BJ - STAND		1997/09/12 15:09:09	
BJ - test	TEST 01 Standard	1997/09/18 10:38:14	
BJ250	250 TESTS	1997/09/17 17:58:59	
ST01	STAND PRODUCT	1997/09/12 16:02:34	
STAND01		1997/09/19 15:46:04	

SET MANHOUR

EXTRACT DATA

CREATE HOST TRANSFER

ANALYZE DATA

END

FIG. 53

SELECTION OF COMPONENT

FILE(E) EDIT(E)

PRODUCT SYMBOL : BJ - 4200 NAME : BJ - 4200

COMPONENT SYMBOL	NAME	PREVIOUS UPDATE DATE
▶ BK	XXXX	1997/09/22 11:09:59
CH	CHECK PROCESS	1997/09/12 11:09:59
KO	PACKAGE	1997/09/18 11:21:07

NEXT DOWNLOAD UPLOAD BACK UP LIST CANCEL ACCESS FLAG END

5301

19970909 10:46:33

FIG. 54

SELECTION OF MODEL

FILE(F)

EDIT(E)

VIEW(V)

PRODUCT NUMBER : BJ - 970909

NAME : 97 - 09 - 09 LOAD

COMPONENT SYMBOL : CH

NAME :

SET MODEL SYMBOL	QUANTITY	NAME	PREVIOUS PUBLICATION DATE
▶ A250 IIQ			
BJC - 4200LX			
BJC - 4200 SYSTEM			
BJC - 420J			
BJC - 420J(BLACK)			
BJC - 4300		XXXXX	1997/09/09 10:46:33
BJC - 430J			

NEXT

REGISTER PUBLICATION

LOOK PUBLICATION

DISPLAY SAME MODEL

END

T36T3T"23462460

FIG. 55

SELECTION OF MODEL										
FILE(F) EDIT(E) VIEW(V)										
<div> <div> <div>FILE</div> <div>EDIT</div> <div>VIEW</div> </div> <div> <div>FILE</div> <div>EDIT</div> <div>VIEW</div> </div> <div> <div>FILE</div> <div>EDIT</div> <div>VIEW</div> </div> </div>										
<div> <div>PRODUCT SYMBOL : BJ - 970909</div> <div>NAME : 097 - 09 - 09 LOAD</div> <div>SET MODEL SYMBOL : BJC - 4300</div> </div>										
<div> <div>COMPONENT SYMBOL : ON</div> <div>NAME :</div> <div>NAME : xxxxxx</div> </div>										
<div> <div>LATEST REVISION NUMBER</div> <div>UPDATE DISPLAY</div> </div>										
S	FORMAL MANAGEMENT NO.	REVISION	UNIT WORK NAME	MANHOUR	USE	CS	FREQUENCY			
N ¹ 3	CH-01-01	1	ELECTRIC CHECKING	0	0	0	0	1		
N ¹ 4	CH-01-02(1)	1	ELECTRIC CHECKING	0	0	0	0	1		
N ¹ 5	CH-01-02(2)	1	ELECTRIC CHECKING	0	0	0	0	1		
N ¹ 6	CH-01-03	1	ELECTRIC CHECKING	0	0	0	0	1		
N ¹ 7	CH-01-04	1	ELECTRIC CHECKING	0	0	0	0	1		
N ¹ 23	CH-07-02(1)	1	SET FRONT COVER	0	0	0	0	1		
N ¹ 24	CH-07-02(2)	1	SET FRONT COVER	0	0	0	0	1		
N ¹ 25	CH-07-01(3)	1	SET FRONT COVER	0	0	0	0	1		
N ¹ 26	CH-07-01(4)	1	SET FRONT COVER	0	0	0	0	1		
No.	FORMAL MANAGEMENT NO.	UNIT WORK NAME	MANHOUR	USE	FREQUENCY	1	2	3	4	5
3	CH-01-01	ELECTRICAL CHECK	0	0	0	1				
<div> <div> <input type="radio"/> CHANGE <input type="radio"/> INSERT <input type="radio"/> ADD </div> <div>OK</div> </div>										

5501 5507 5506 5502 5503 5504 5505

1. *Staphylococcus aureus* (Staph. aureus) is a common cause of skin infections, such as impetigo and boils. It is also a leading cause of hospital-acquired infections, including pneumonia and bloodstream infections.

FIG. 56

XXXXXX										
<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="display: flex; gap: 5px;"> <div style="border: 1px solid black; padding: 2px;">📄</div> <div style="border: 1px solid black; padding: 2px;">🔍</div> <div style="border: 1px solid black; padding: 2px;">✕</div> <div style="border: 1px solid black; padding: 2px;">📁</div> <div style="border: 1px solid black; padding: 2px;">📁</div> </div> </div>										
FORMAL MANAGEMENT NO. PU-03-01			UNIT WORK NAME : MOTOR ATTACHMENT				TOTAL MANHOUR :		0	NEXT UNIT WORK

NO.	ELEMENT WORK NAME	REVISION	MANHOUR	US	CS	SET CONDITION
1	SET DOUBLE GEAR TO OPPOSITE SIDE OF AXIS IN ORDER OF SMALL GEAR DIAMETER	1	0	0	0	
*						

COMMENT 1 : TO OPPOSITE SIDE OF AXIS

OBJECT : DOUBLE GEAR

COMMENT 2 : IN ORDER OF SMALL GEAR DIAMETER

VERB : SET

5604

5605

5603

5602

5601

T06T0T"924E3460

FIG. 57

EDITING OF ANALYSIS MATERIAL



FILE(E) EDIT(E) VIEW(V)

PRODUCT GENRE :

ALL

TYPE/COMMENT 1	OBJECT	COMMENT 2	VERB	ANALYSIS SYMBOL	MAN/ HOUR	USE/ FREQ.	COUNT	SET DATE
▲	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/G1/N>6/3	15	0 1 1	0 97/09/09 9:52
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/E/02/N/6	11	0 1 1	0 97/09/09 9:53
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/G1/N>6/3	15	0 1 1	0 97/09/09 9:55
		ELEMENT WORK 01		VERB	-50/G1/N>6/3	15	0 1 1	0 97/09/09 16:34
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/G1/N>6/3	15	0 1 1	0 97/09/09 19:09
		CARRIAGE LOCK		APPLY	Time100/Rate100	100	100 1 1	1 97/09/09 19:16
	ASSEMBLE MOTOR	PRINTER CHASSIS	INSERT & SET	M211/1/10		50	1 1 1	1 97/09/09 17:00
		PRINTER CHASSIS		TURN INSIDE OUT	T1221/M2311/0/0	12	0 1 1	0 97/09/09 17:34
	1		1		T2221/M1211/0/1	24	0 1 1	0 97/09/09 17:20
	2		2		T1221/M2311/0/0	12	0 1 1	0 97/09/09 17:24
		PRINTER CHASSIS	ASSEMBLE PR GUIDE	SET		15	0 1 1	0 97/09/09 11:24
	dgd1afdfas		fdasfdasfasad	*		16	0 1 1	0 97/09/09 12:10
	dsdsfisdaf		fdasfdsdffds	T21121/M1111/0/1		13	0 1 1	0 97/09/09 12:10
	dgd1afdfas		fdasfdasfasad	*		16	0 1 1	0 97/09/09 13:39
	PRINTER CHASSIS	ASSEMBLE PR GUIDE	SET			15	0 1 1	0 97/09/09 14:00
	PRINTER CHASSIS	ASSEMBLE PR GUIDE	SET			15	0 1 1	0 97/09/09 14:00
	PRINTER UNIT		SET	Time100/Rate100		100	100 1 1	0 97/09/09 14:04

FIELD

FIG. 58

5801
5802
5803
5804
5805

OPERATION ANALYSIS

1 SET MAIN BODY TO
PREDETERMINED POSITION

TOTAL SIMO VALUE : 0

TOTAL MANHOURLY VALUE: 15

NEXT ELEMENT WORK

NO.	CONTENTS OF OPERATION	WF/OS	SET CONDITION	MANHOURLY	USE	REMARKS
▶ 1	XXXXXX	PU	-60/Gr1/N/>6/-3	15	0	
*						

FIG. 59

5901

☐ 1. PU

☐ 2. GET

☐ 3. M

☐ 4. MA

☐ 5. ASY

☐ 6. DSY

☐ 7. R

☐ 8. UMAC

☐ 9. MP

☐ 10. BODY

☐ 11. PU

☐ 12. GET

☐ 13. M

☐ 14. MA

☐ 15. ASY

☐ 16. DSY

☐ 17. R

☐ SIMO

5902

SELECT

CANCEL

FIG. 60

XXXXXX

PU

PICK UP

MANUAL

1 :	MOVING DISTANCE	1	-10cm	2	+10cm	3	>50cm	4	5	6
2 :	GRIP TYPE		Qr-3		Qr-2					
3 :	PRE-POSITIONING		NO		YES					
4 :	MAIN SIZE		-10mm		-6mm					
5 :	WEIGHT		<3Kg		>3Kg					
6 :										

SET

CANCEL

SET VALUE

FORMULA

6001

6002

6003

TOP 224560

FIG. 61

FORMULA

TURN

CHANGE DIRECTION OF BODY

MANUAL

FORMULA : 10 * m

VARIABLE	VARIABLE NAME	VALUE	UNIT
m :	THE NUMBER OF TIMES OF OPERATION OF CHANGING DIRECTION		COUNT
n :			
p :			
q :			
r :			
s :			

SET

CANCEL

SET VALUE

FIG. 62

INQUIRY OF LOG

VARIATION AMOUNT : 10

USE : 0

REASON CODE : 1

CHANGE REASON : SET ▼

OK Clear

6201 6202 6203 6204 6205 6206

0973326-104901

FIG. 63

6301 6302

CORRECTION OF CHANGE LOG

DATE

1997

09

22

○ = ○ FROM

○ BEFORE ○ ~

SEARCH

NO.	UNIT WORK NAME	CODE	CHANGE REASON	NEW MANHOUR	(NEW) MANUAL	(NEW) USE	PREVIOUS (PREVIOUS) MANHOUR	(PREVIOUS) USE	CHANGE DATE
▶	CH-01-01: ELECTRICAL CHECK	1	SET	10	10	0	0	0	1997/09/22 14.30.00

REASON CODE

1

CHANGE REASON

SET

OK

CtR

END

FIG. 64

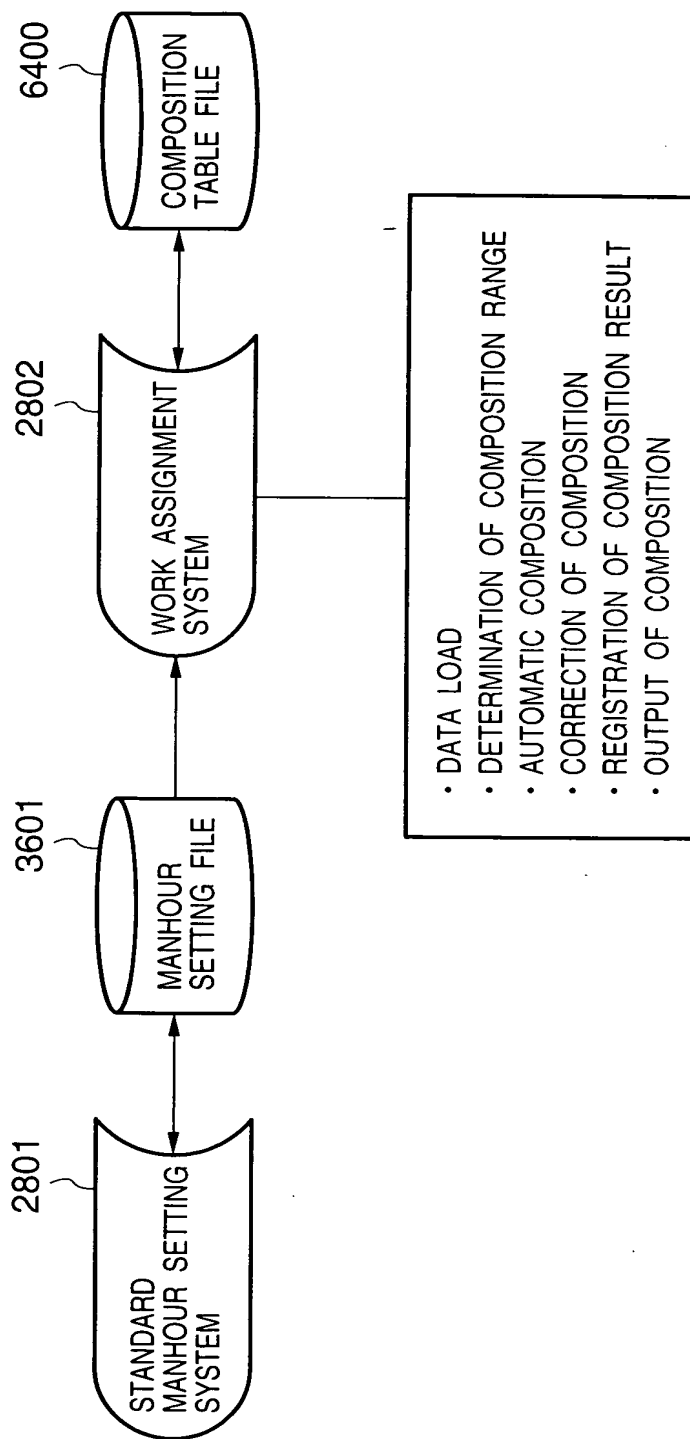


FIG. 65

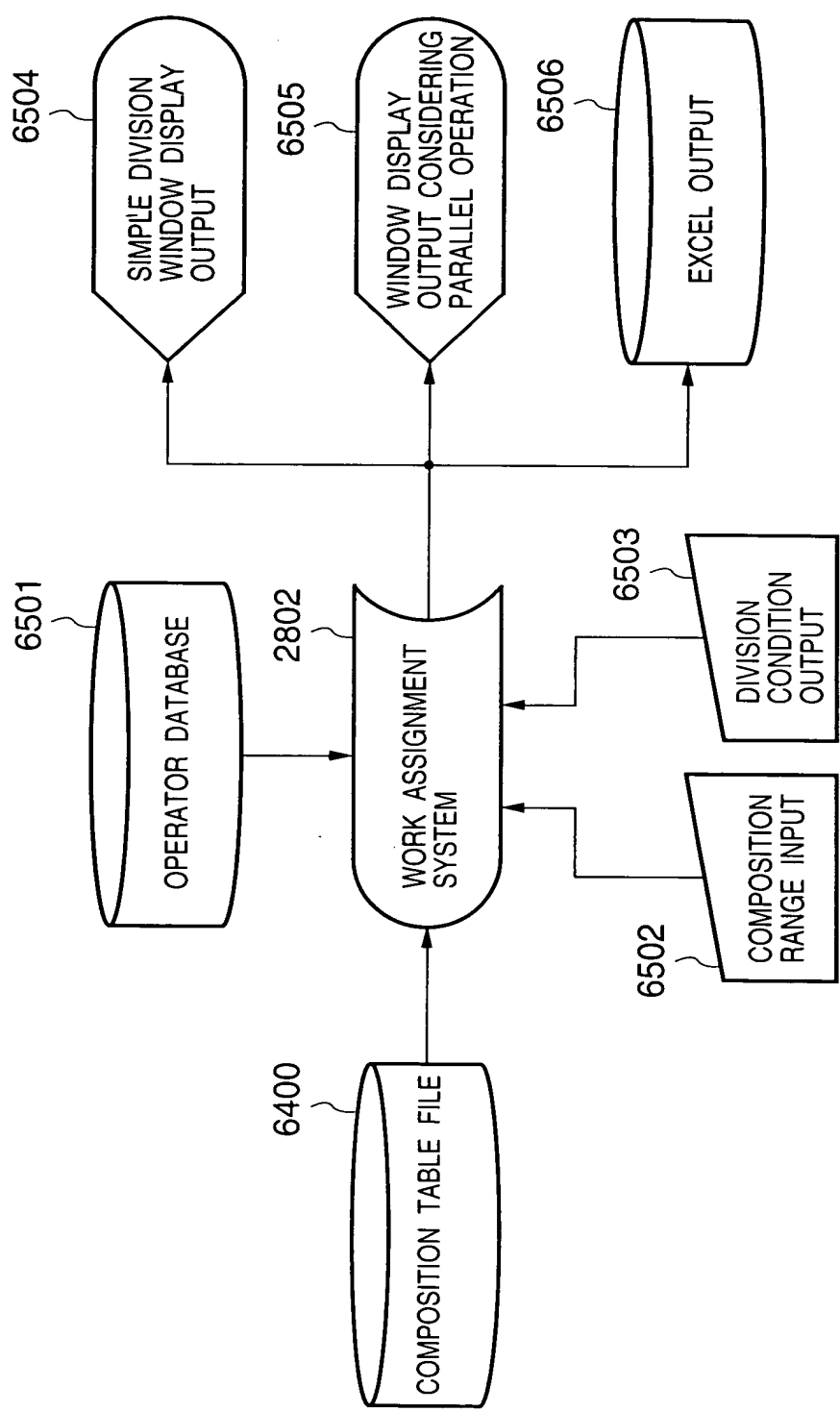


FIG. 65

FIG. 66

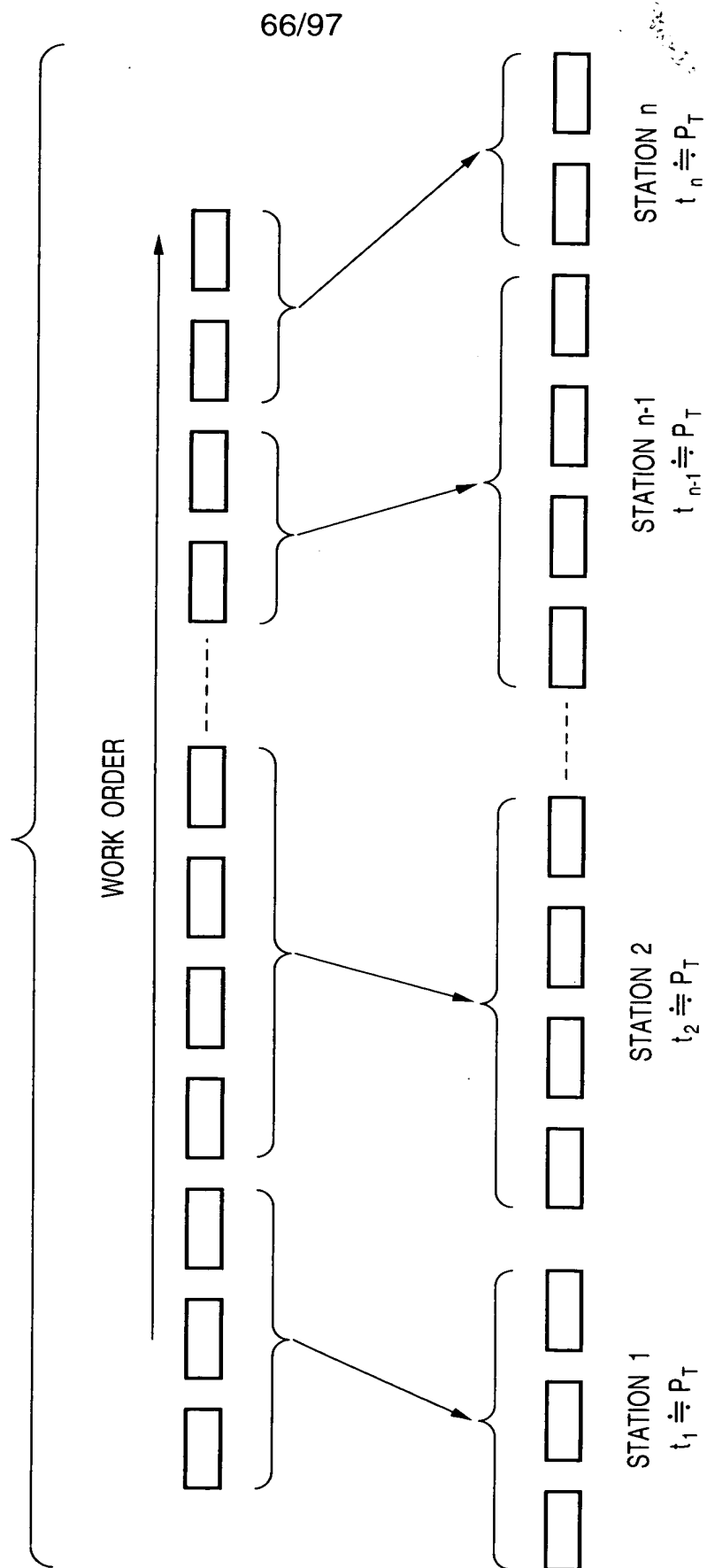


FIG. 67

		▼	▲
FILE(F) EDIT(E) INPUT(I) TOOL(O)			
<div>MODEL</div> <div>GP55</div>			
<div>UNIT</div> <div></div>			
STANDARD NO.	WORK NAME	MANHOUR	
0001	STICK HANDY CUT TAPE	134	
0002	SET LABELS ON MAIN BODY	550	
0003	WEIMAN REMOVAL	270	
0004	ASSEMBLE OUTER CASE	365	
0005	FIT TOP PAD	268	
0006	STICK LARGE-SIDE ORDER LABEL	117	
...			

FIG. 68

SIMPLE DIVISION

—		▼	▲
—	FILE(F) EDIT(E)	◆	

St 1

0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270

St 2

0004	ASSEMBLE OUTER CASE	365
0005	FIT TOP PAD	268
0006	STICK LARGE-SIDE ORDER LABEL	117

⋮

FIG. 69

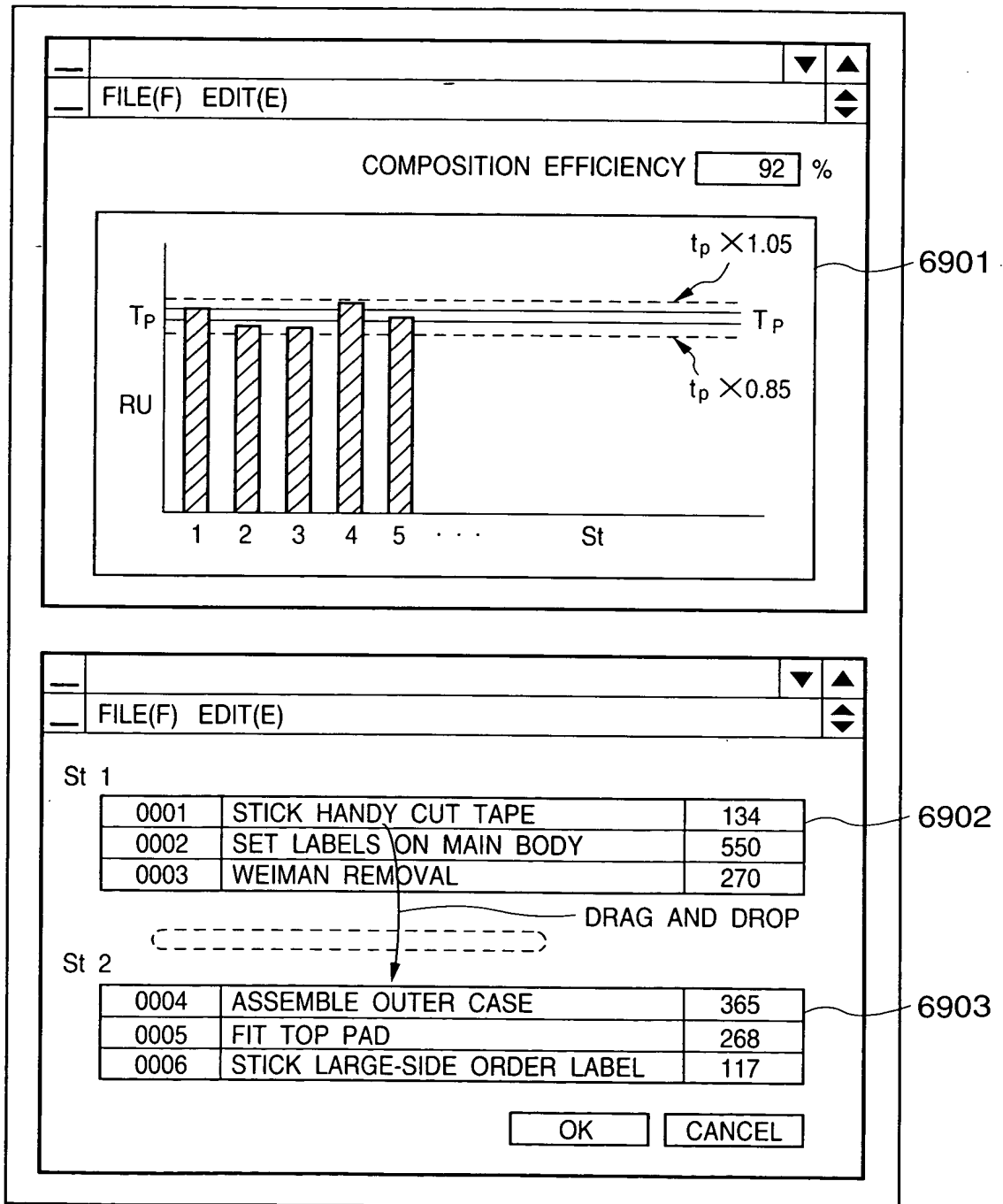


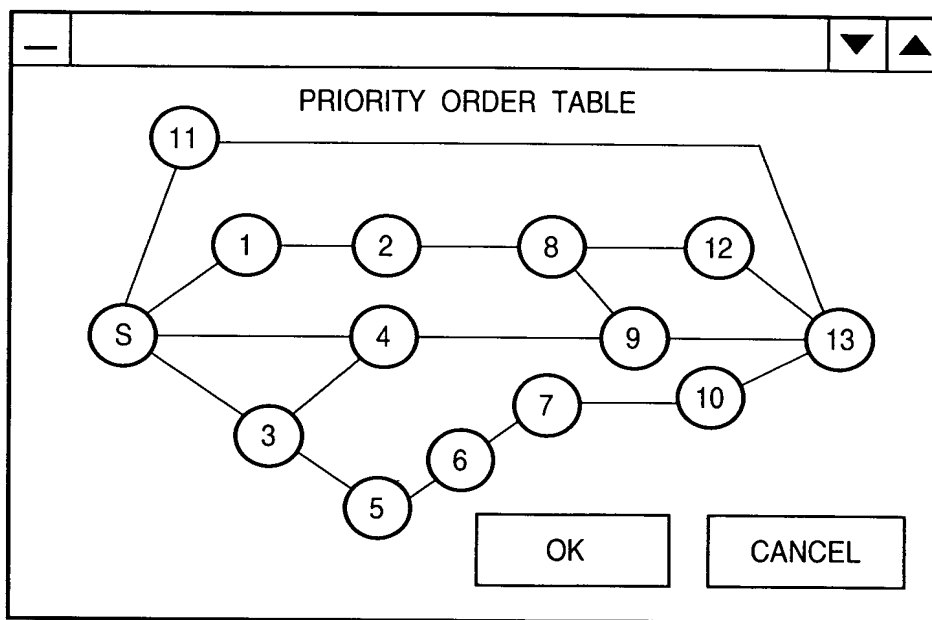
FIG. 70

FIG. 71

PARALLEL DIVISION

				▼	▲
PLAN 2		PLAN 1			
St 1		St 1			
1		1	STICK HANDY CUT TAPE	99	
2		2	SET LABELS ON MAIN BODY	78	
8		3	WEIMAN REMOVAL	134	
St 2		St 2			
3		4	ASSEMBLE OUTER CASE	732	
4		5	FIT TOP PAD	268	
5		6	STICK LARGE-SIDE ORDER LABEL	117	
			⋮		

09733726-101501

FIG. 72

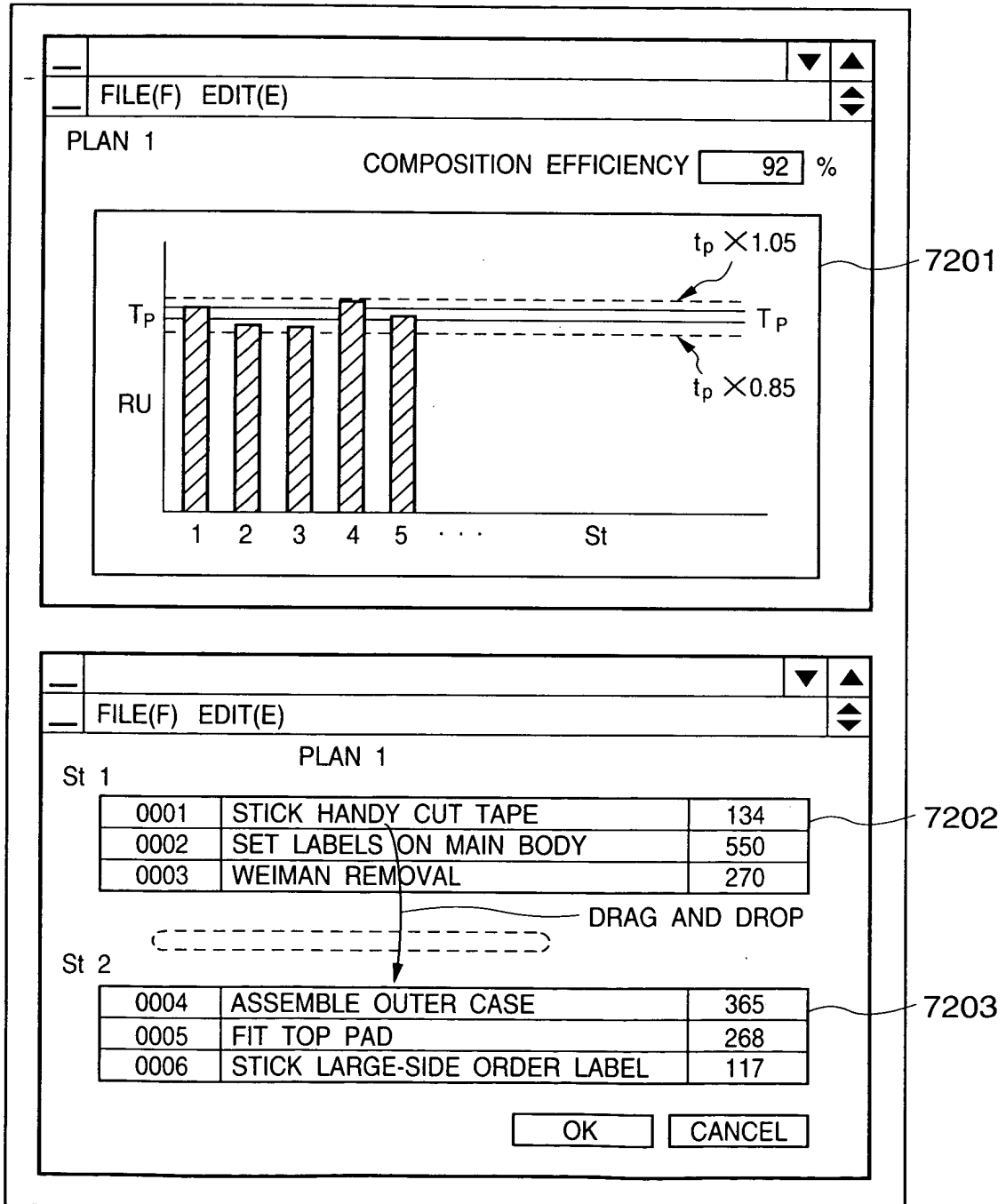


FIG. 73

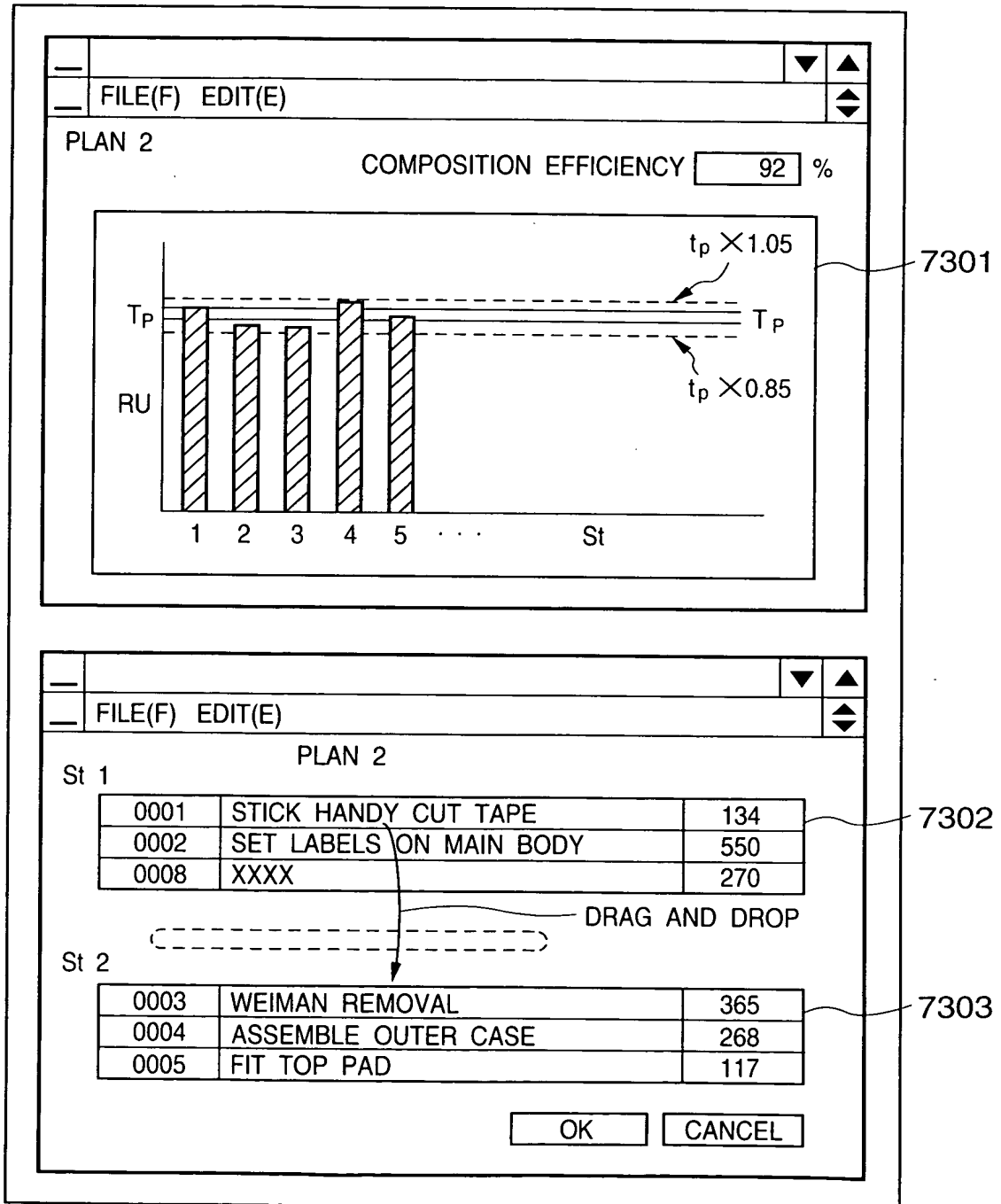


FIG. 74

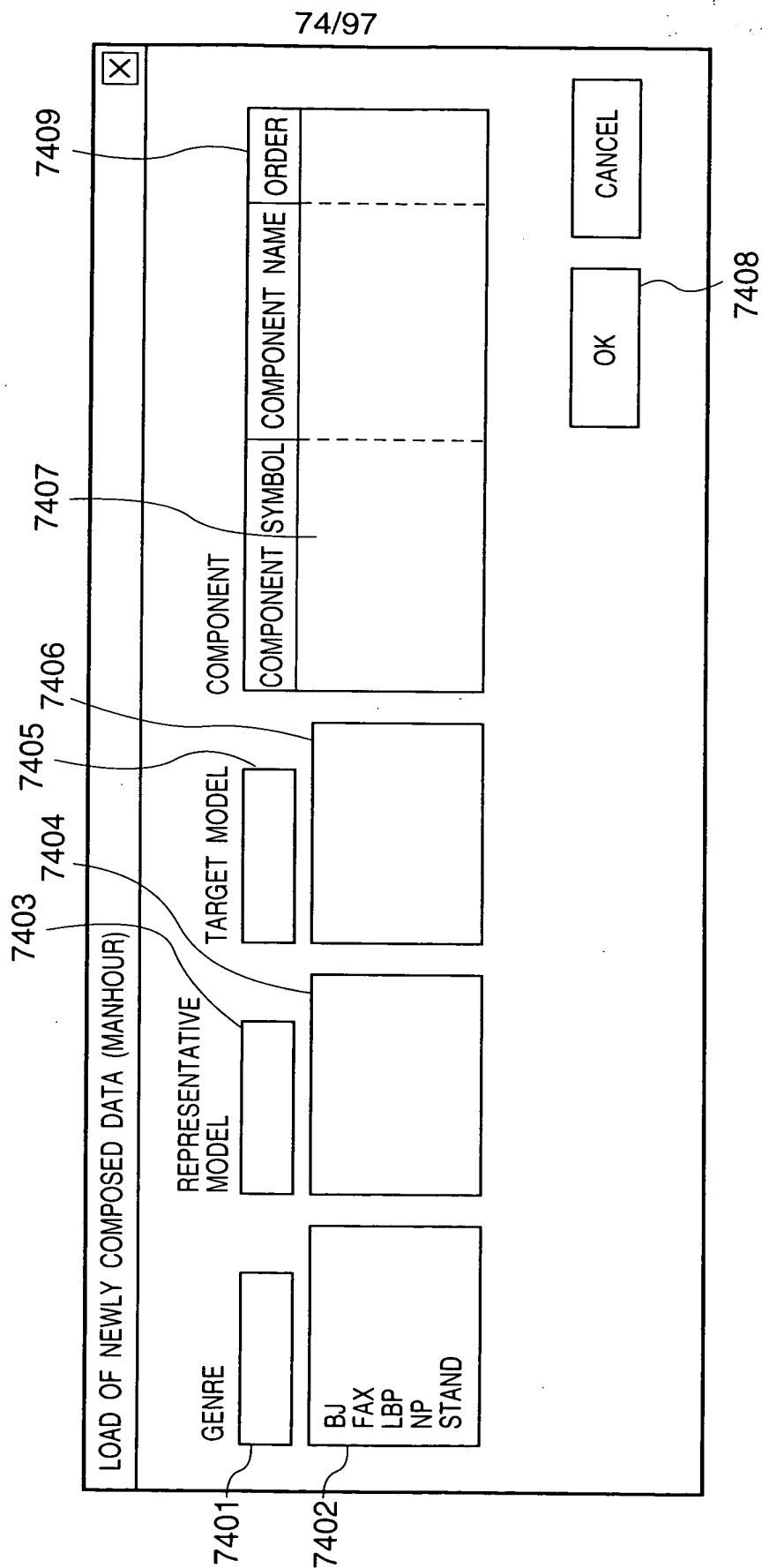
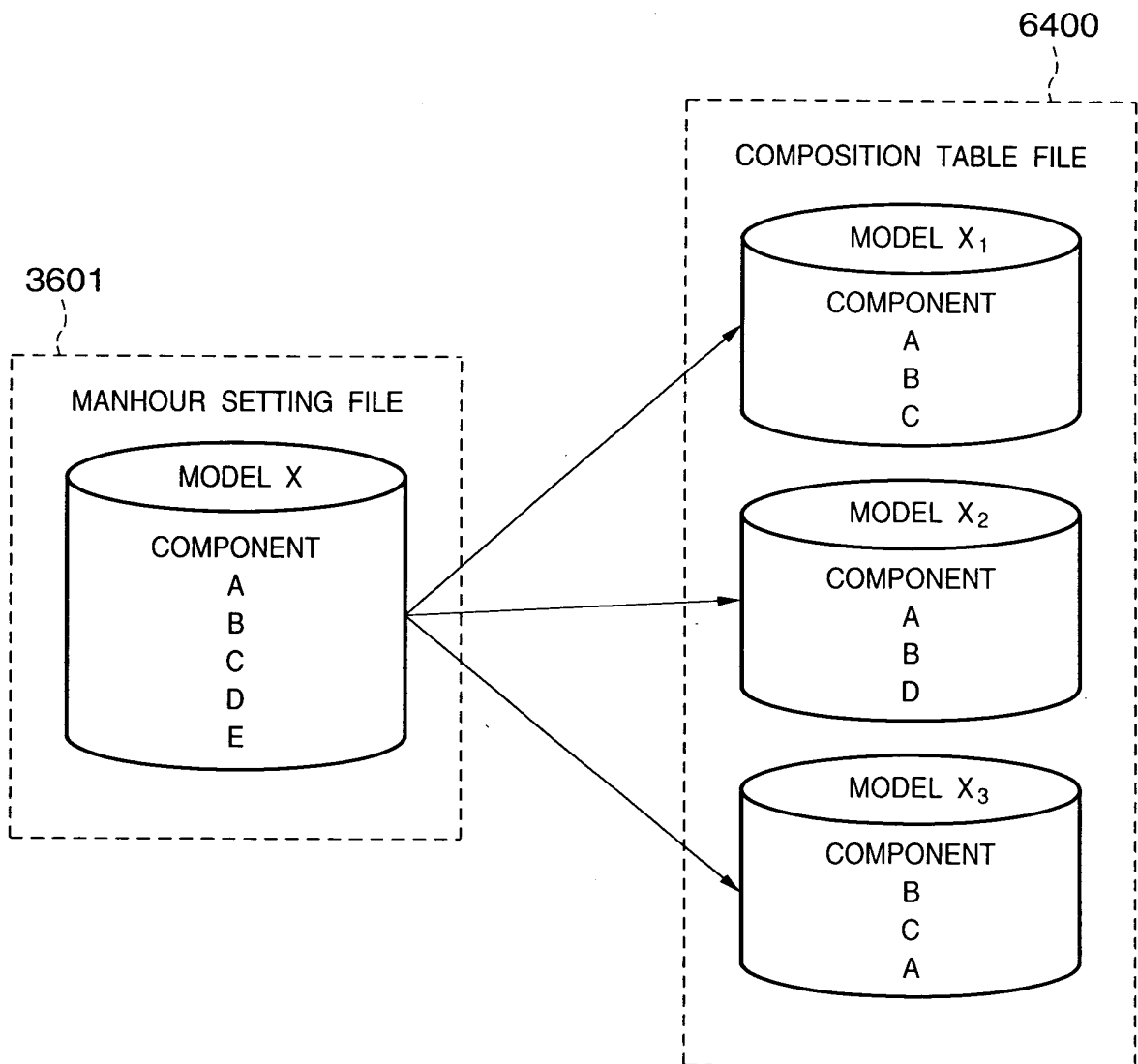


FIG. 75



7710

FIG. 78

INSERTION OF UNIT WORK ✕

NEW WORK WILL BE INSERTED BEFORE
"STICK CHECK SHEET SERIAL NO."

INPUT WORK NAME AND PROVISIONAL MANHOUR VALUE

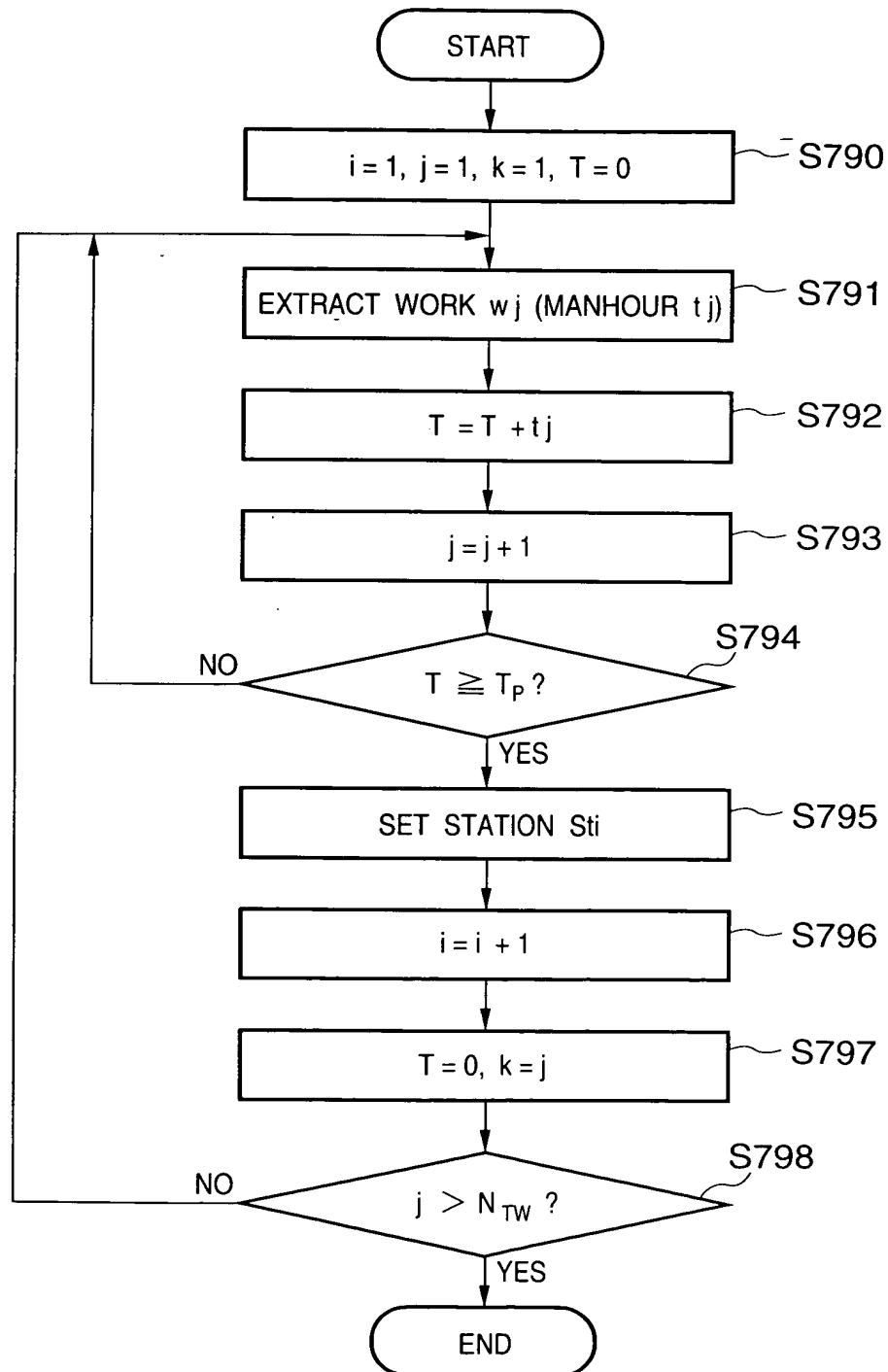
7801 UNIT WORK NAME :

7802 PROVISIONAL MANHOUR : (RU)

REMARKS :

OK CANCEL

FIG. 79



[illegible]

tp
tp*1.05
tp*0.85
t

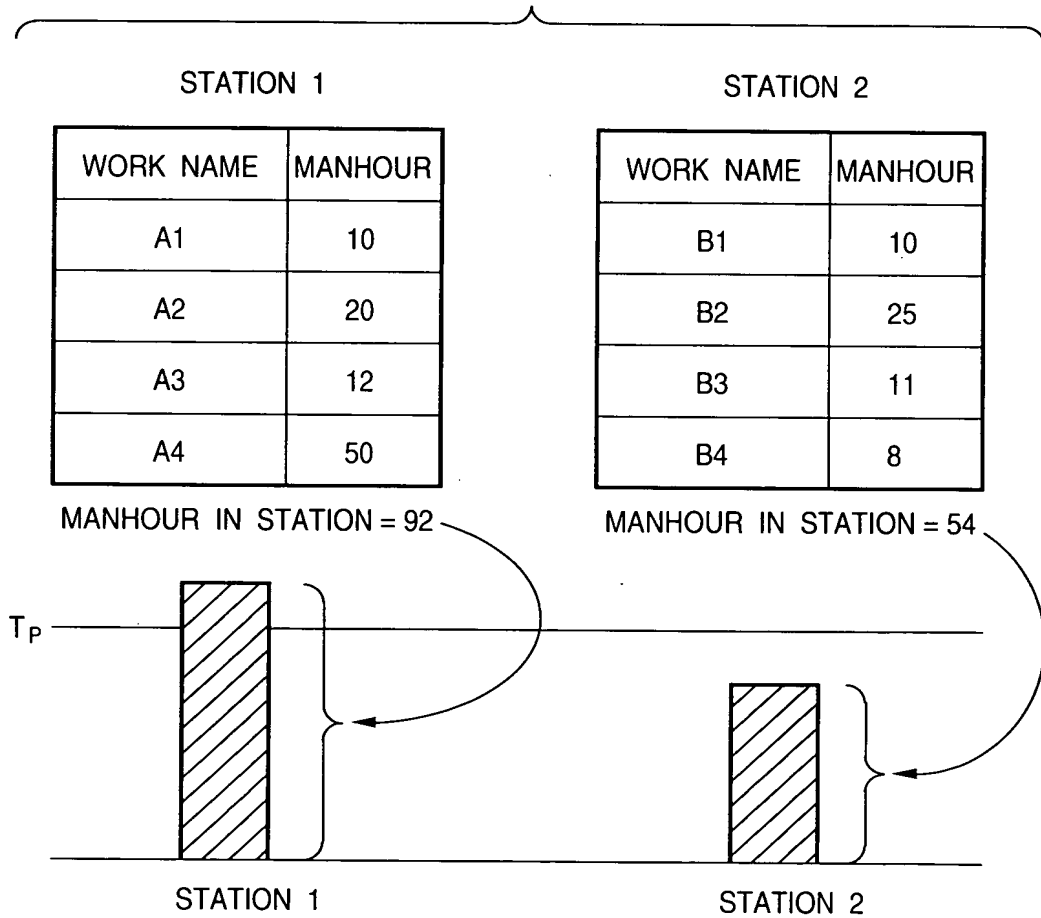
FIG. 81

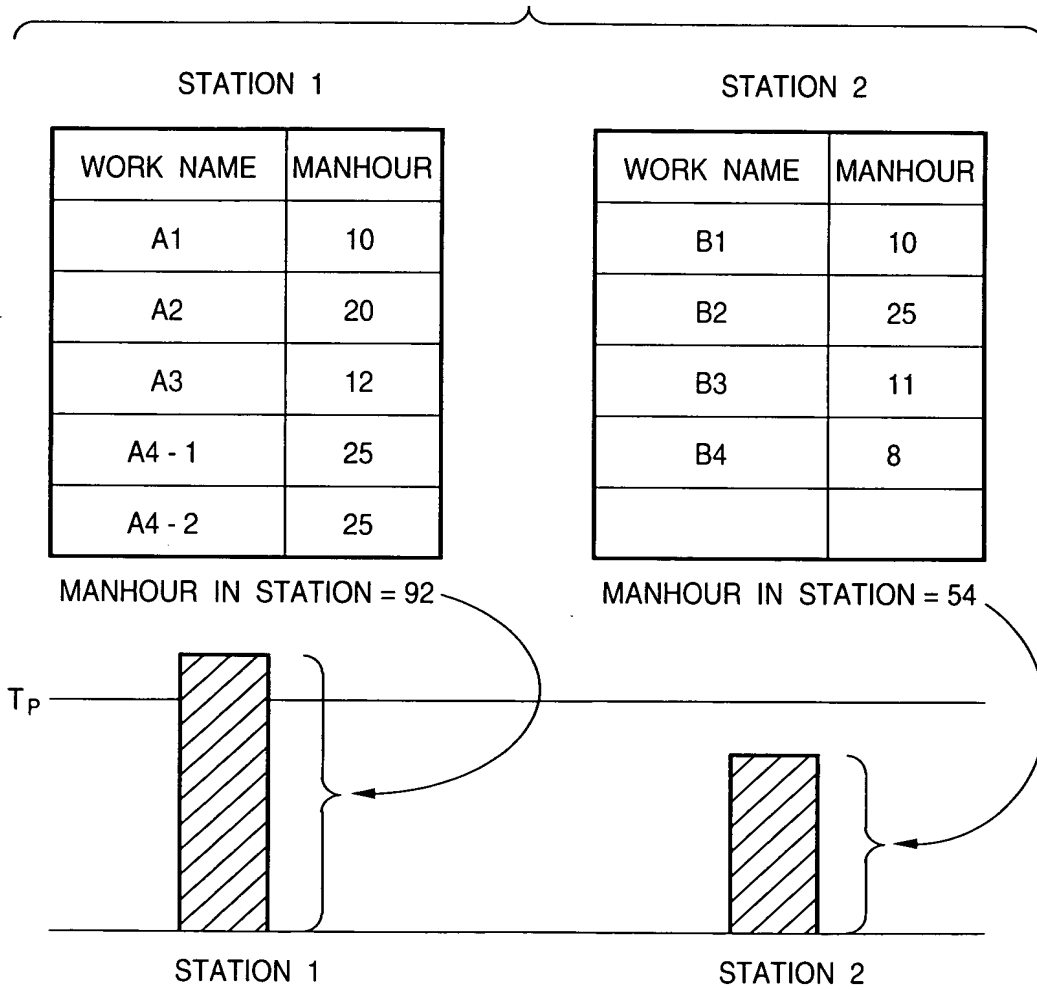
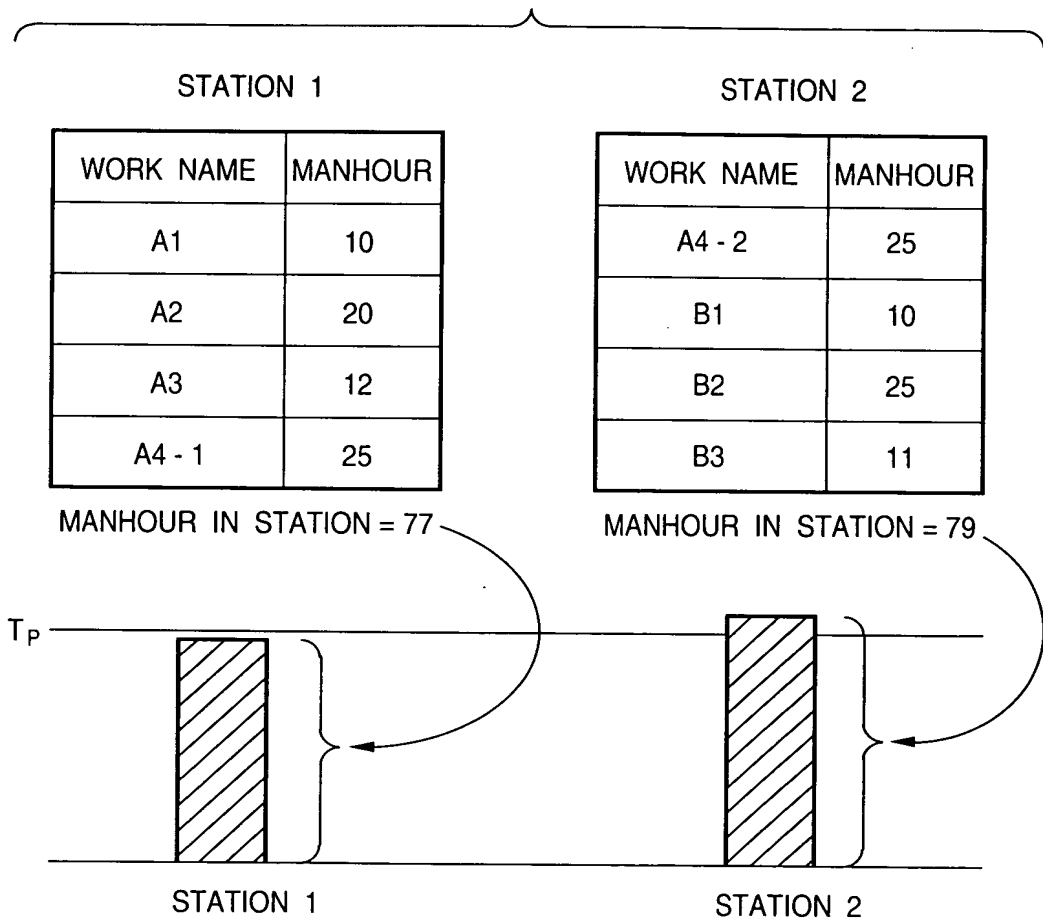
FIG. 82

FIG. 83



09753726-101901

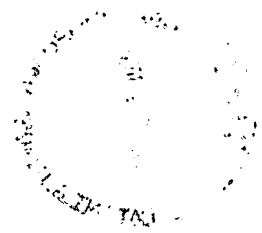


FIG. 84

PARALLEL OPERATION / INTEGRATION OF STATIONS

TARGET STATION : 1

8401

THE NUMBER OF STATIONS

2

8402

OK

CANCEL

09753726-101501

FIG. 85

FILE(E) EDIT(E) VIEW(V) TOOL(T)

OPERATOR 1

S11

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
START	0	0	No.
UNIT WORK NAME 1	34	10	No.01
UNIT WORK NAME 2	255	46	No.02
UNIT WORK NAME 6	92	26	No.06
UNIT WORK NAME 7	52	0	No.07
UNIT WORK NAME 8	52	0	No.08
UNIT WORK NAME 9	0	36	No.09

TOTAL 585 (RU)

PF 83.6%

OPERATOR 2

S12

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT WORK NAME 3	156	0	No.03
UNIT WORK NAME 4	34	0	No.04
UNIT WORK NAME 5	138	23	No.06
UNIT WORK NAME 10	71	48	No.10
UNIT WORK NAME 11	138	30	No.11
UNIT WORK NAME 12	97	20	No.12
UNIT WORK NAME 13	88	0	No.14
UNIT WORK NAME 14	46	18	No.15
UNIT WORK NAME 15	546	15	No.16
UNIT WORK NAME 16	58	20	No.17

TOTAL 1548 (RU) xxxxxx

PF 23.5 %

OPERATOR 3

S13

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT WORK NAME 13	30	40	No.13
UNIT WORK NAME 16	303	131	No.18

TOTAL 572 (RU)

PF 96.7%

OPERATOR 4

S14

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT WORK NAME 19	84	26	No.19
UNIT WORK NAME 20	120	20	No.20
UNIT WORK NAME 21	310	66	No.21

TOTAL 623 (RU)

PF 95.2%

OPERATOR 5

S15

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT WORK NAME 22	146	71	No.22
UNIT WORK NAME 23	106	26	No.23
UNIT WORK NAME 24	61	0	No.24
UNIT WORK NAME 25	51	10	No.25
END	0	0	No.X

TOTAL 486 (RU)

PF 73.6%

PARALLEL STATIONS

1 2 3 4 5

900
720
540
360
180
0

--- tp
--- tp*1.05
--- tp*0.85
--- t

G STANDARD NO. WORK NAME

WF MEANS MA-CHINE MANHOUR

PROVISIONAL REMARKS

COMPOSITION EFFICIENCY 116 %

NET COMPOSITION EFFICIENCY %

COMPOSITION MODE: PRIORITY ORDER SCHEME

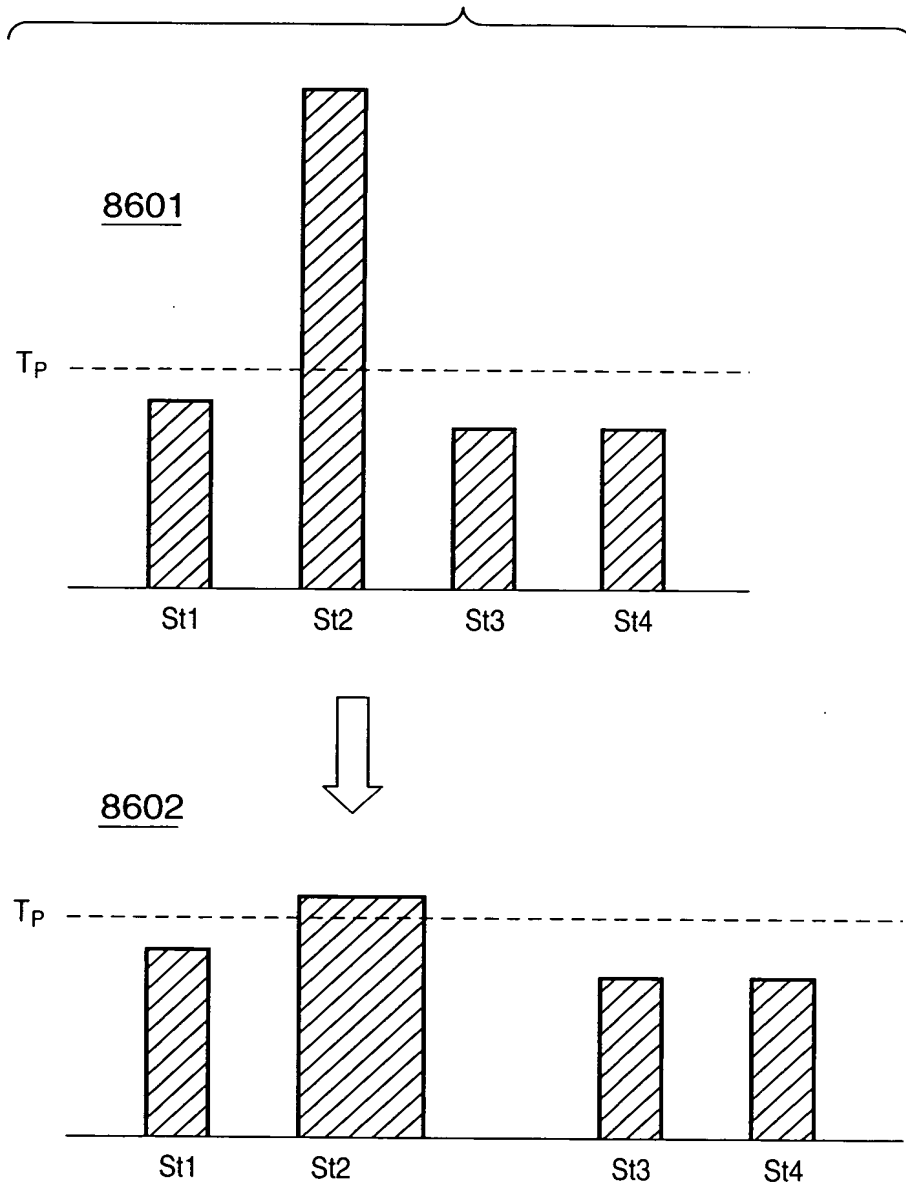
FIG. 86

FIG. 87

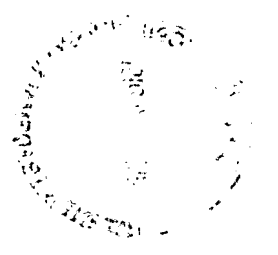
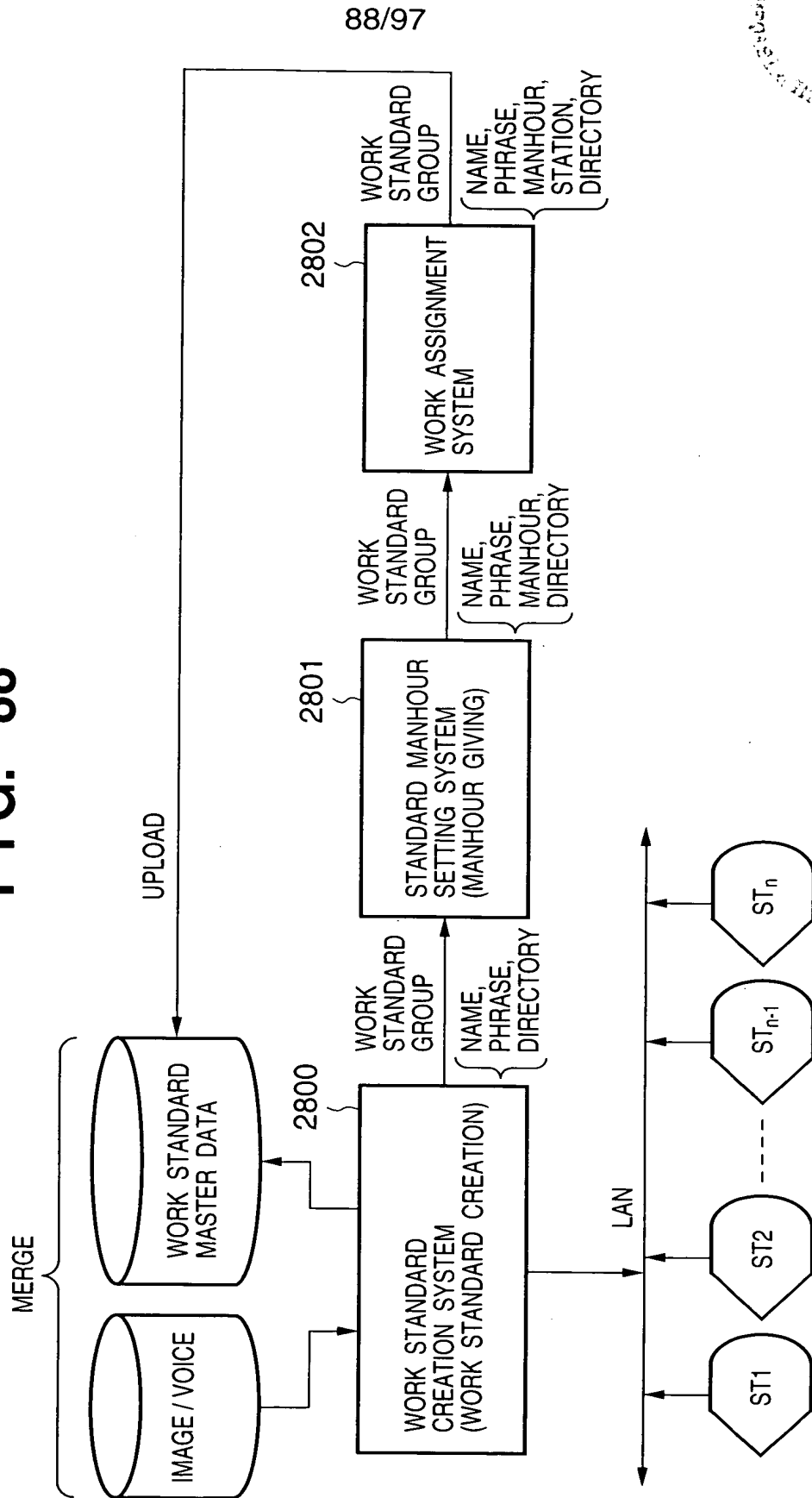
09753726-101501

The figure shows a 'USER REGISTRATION' dialog box with a close button (X) in the top right corner. It contains five input fields and two buttons. The fields are labeled on the left and have corresponding reference numerals on the right: 'NAME CODE : 12345' (8701), 'NAME : TANAKA ICHIRO' (8702), 'POSITION : kumitate' (8703), 'PASSWORD : 12345' (8704), and 'AUTHORITY :' (8705). The 'POSITION' field is a dropdown menu. At the bottom are 'OK' and 'CANCEL' buttons.

Field Label	Value	Reference Numeral
NAME CODE :	12345	8701
NAME :	TANAKA ICHIRO	8702
POSITION :	kumitate	8703
PASSWORD :	12345	8704
AUTHORITY :		8705

OK CANCEL

FIG. 88



T05T07 922E2259

FIG. 89

DIRECTORY NAME	IMAGE DATA	OPERATION (VERB)	PARAMETER 1	PARAMETER 2	PARAMETER 3
xxxxx1	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 10mm	TORQUE 10Kg.M
xxxxx2	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 20Kg.M
xxxxx3	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 30Kg.M
...
yyyyy1	ROTATE	ROTATE	CLOCKWISE	DISTANCE MOVEMENT 20mm	
yyyyy2	ROTATE	ROTATE	COUNTERCLOCKWISE	DISTANCE MOVEMENT 20mm	
...
zzzzz1	OPEN	OPEN	OPEN UPWARD	DISTANCE MOVEMENT 30mm	WEIGHT 100g
zzzzz2	OPEN	OPEN	OPEN DOWNWARD	DISTANCE MOVEMENT 40mm	WEIGHT 200g
...

SECRET

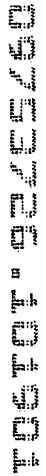


FIG. 91

9101 9102

SETTING OF COMPONENT SYMBOL

PRODUCT SYMBOL : BJ - 970909

COMPONENT SYMBOL : CH

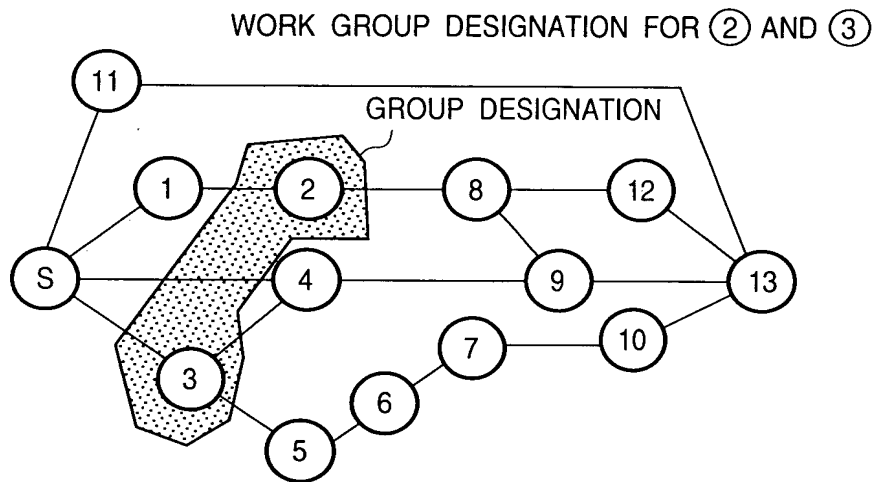
COMPONENT NAME : CHECK

OK SEARCH COMPONENT CANCEL

970909 BJ - 970909

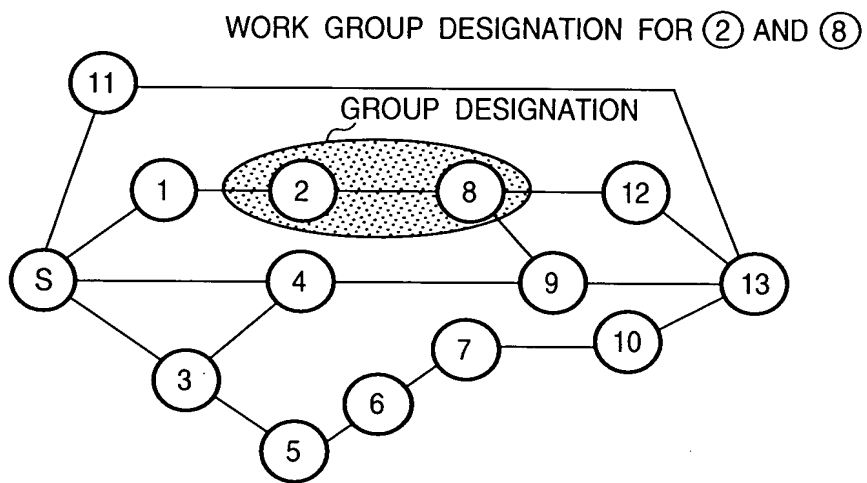


FIG. 92

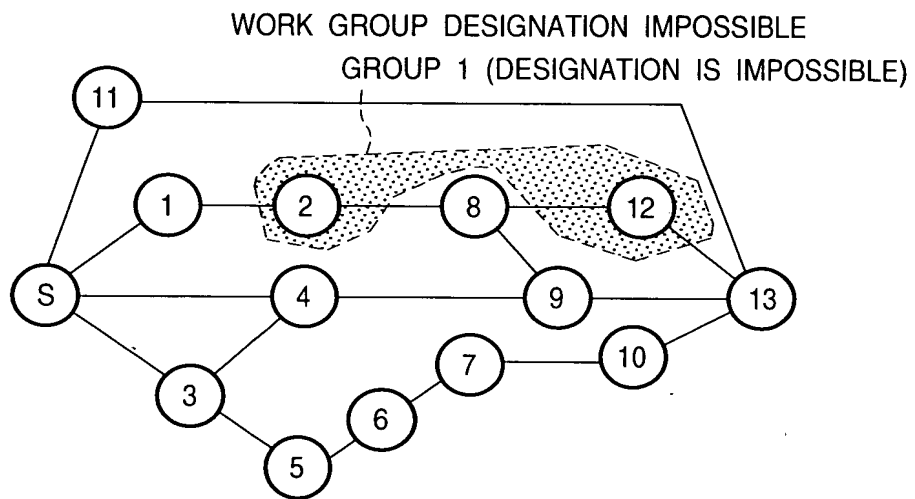


09753726-101901
FOR "92/97"

FIG. 93

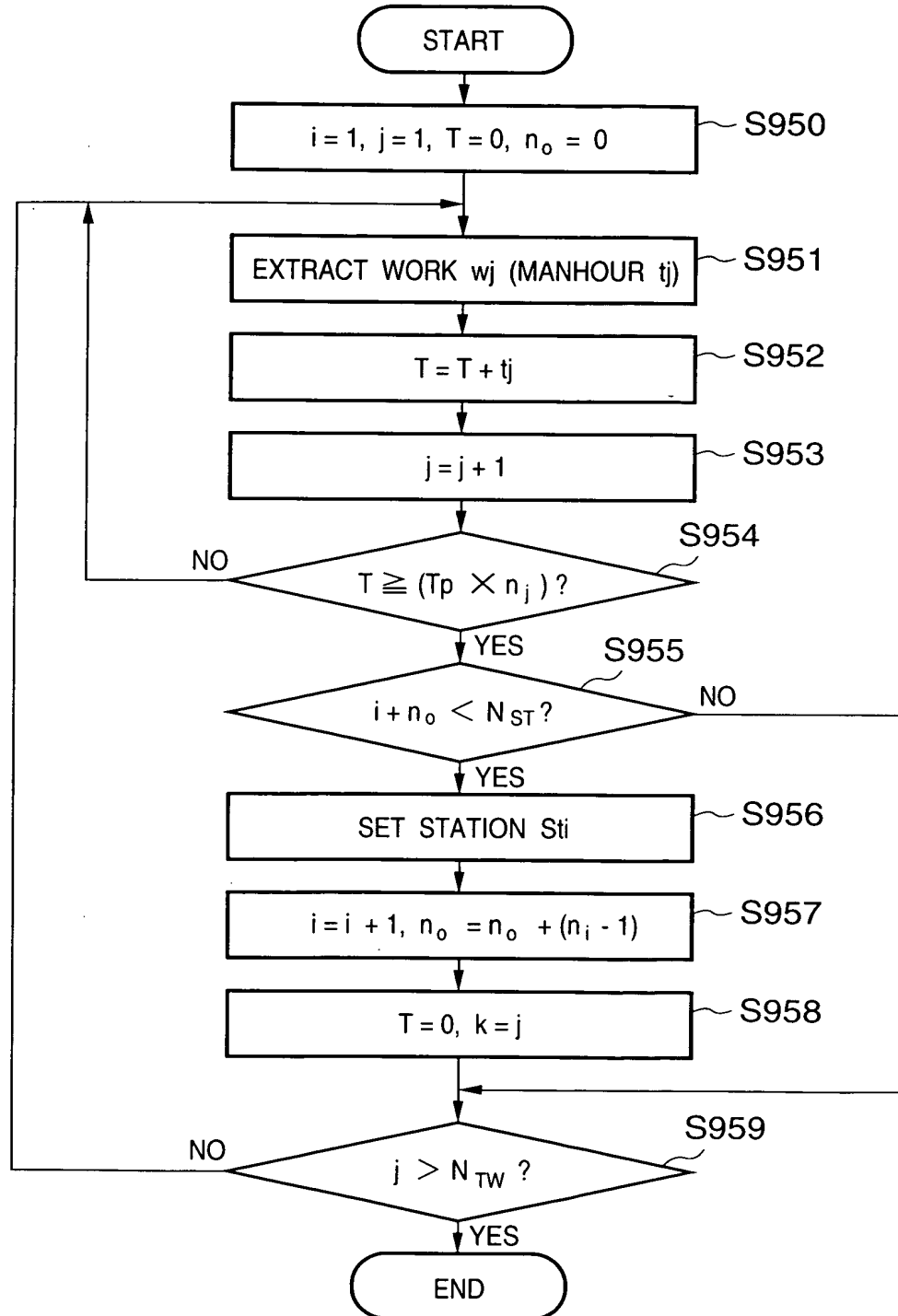


05753726-104904
TOP SECRET 93455450

**FIG. 94**

95/97

FIG. 95

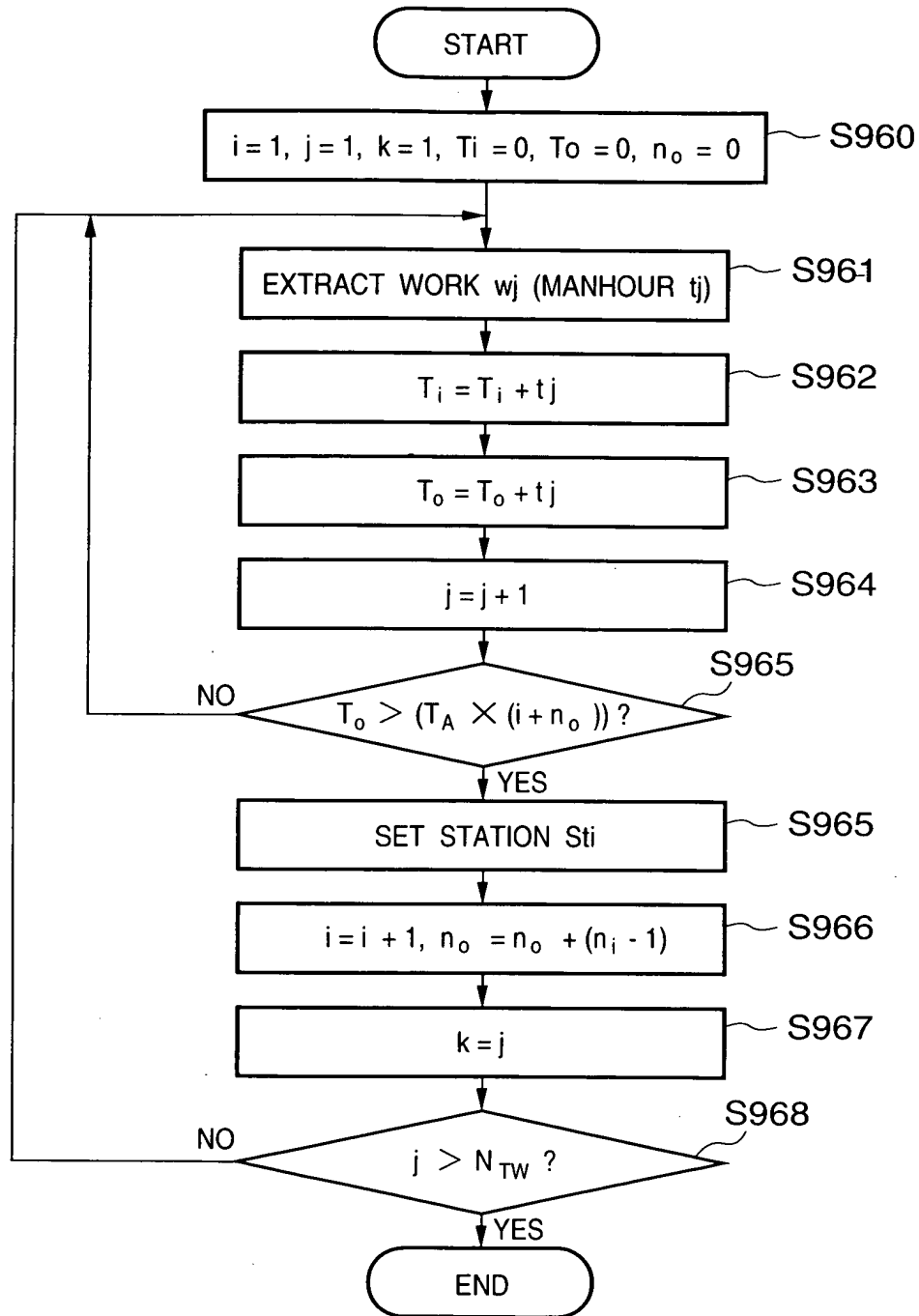


N_{ST} : THE NUMBER OF STATIONS
 n_i : i STATION PARALLEL NUMBER
 n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

09753726-101904

96/97

FIG. 96



N_{ST} : THE NUMBER OF STATIONS

T_i : i STATION MANHOUR

T_A : STATION MANHOUR AVERAGE VALUE

$$T_A = WF / N_{ST}$$

T_o : TOTAL ACCUMULATED MANHOUR

n_i : i STATION PARALLEL NUMBER

n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

095372-404904
TOP SECRET

FIG. 97

FILE(E) EDIT(E) VIEW(V) TOOL(T)

X

-

OPERATOR 1

S1

WORK NAME	WF	PROV. SIONAL MAN-CHINE HOUR	MAN-CHINE UAL
START	0	0	No.
UNIT WORK NAME 1	34	10	No.01
UNIT WORK NAME 2	255	46	No.02
UNIT WORK NAME 6	92	26	No.06
UNIT WORK NAME 7	52	0	No.07
UNIT WORK NAME 8	52	0	No.08
UNIT WORK NAME 9	0	36	No.09

TOTAL 585 (RU)

OPERATOR 2

S2

WORK NAME	WF	PROV. SIONAL MAN-CHINE HOUR	MAN-CHINE UAL
UNIT WORK NAME 3	156	0	No.03
UNIT WORK NAME 4	34	0	No.04
UNIT WORK NAME 5	138	23	No.06
UNIT WORK NAME 10	71	48	No.10
UNIT WORK NAME 11	138	30	No.11
UNIT WORK NAME 12	97	20	No.12
UNIT WORK NAME 13	88	0	No.14
UNIT WORK NAME 14	46	18	No.15
UNIT WORK NAME 15	546	15	No.16
UNIT WORK NAME 17	58	20	No.17

TOTAL 1548 (RU) xxxxxx

OPERATOR 3

S3

WORK NAME	WF	PROV. SIONAL MAN-CHINE HOUR	MAN-CHINE UAL
UNIT WORK NAME 13	30	40	No.13
UNIT WORK NAME 16	303	131	No.18

TOTAL 572 (RU)

OPERATOR 4

S4

WORK NAME	WF	PROV. SIONAL MAN-CHINE HOUR	MAN-CHINE UAL
UNIT WORK NAME 19	84	26	No.19
UNIT WORK NAME 20	120	20	No.20
UNIT WORK NAME 21	310	66	No.21

TOTAL 6238 (RU)

OPERATOR 5

S5

WORK NAME	WF	PROV. SIONAL MAN-CHINE HOUR	MAN-CHINE UAL
UNIT WORK NAME 22	146	71	No.22
UNIT WORK NAME 23	106	26	No.23
UNIT WORK NAME 24	61	0	No.24
UNIT WORK NAME 25	51	10	No.25
END	0	0	No.X

TOTAL 486 (RU)

OPERATOR 6

S6

WORK NAME	WF	PROV. SIONAL MAN-CHINE HOUR	MAN-CHINE UAL
UNIT WORK NAME 22	146	71	No.22
UNIT WORK NAME 23	106	26	No.23
UNIT WORK NAME 24	61	0	No.24
UNIT WORK NAME 25	51	10	No.25
END	0	0	No.X

TOTAL 486 (RU)

TOTAL 585 (RU)

TOTAL 1548 (RU) xxxxxx

TOTAL 572 (RU)

TOTAL 6238 (RU)

TOTAL 486 (RU)

PF 83.6%

PF 117.3%

PF 96.7%

PF 95.2%

PF 73.6%

PARALLEL STATIONS

900
720
540
360
180
0

1
2
3
4
5

G STANDARD NO. WORK NAME

WF MEANS PROVISIONAL CHINE MAN-CHINE HOUR REMARKS

COMPOSITION EFFICIENCY 96.43 %
 NET COMPOSITION EFFICIENCY %

COMPOSITION MODE: PRIORITY ORDER SCHEME